

FIG. 1

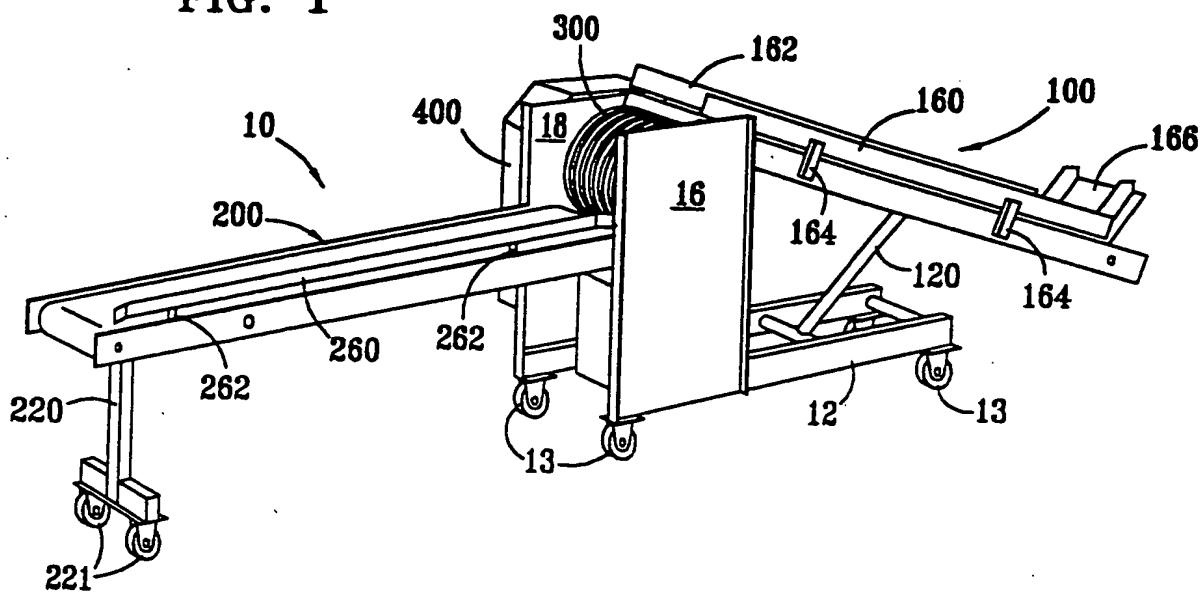


FIG. 2

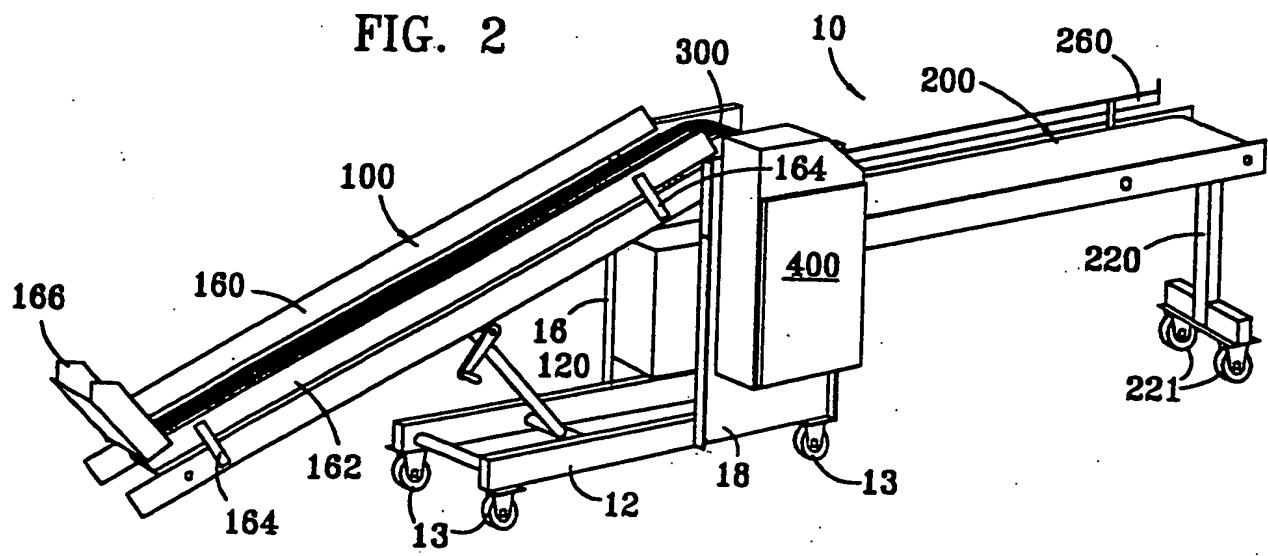


FIG. 3

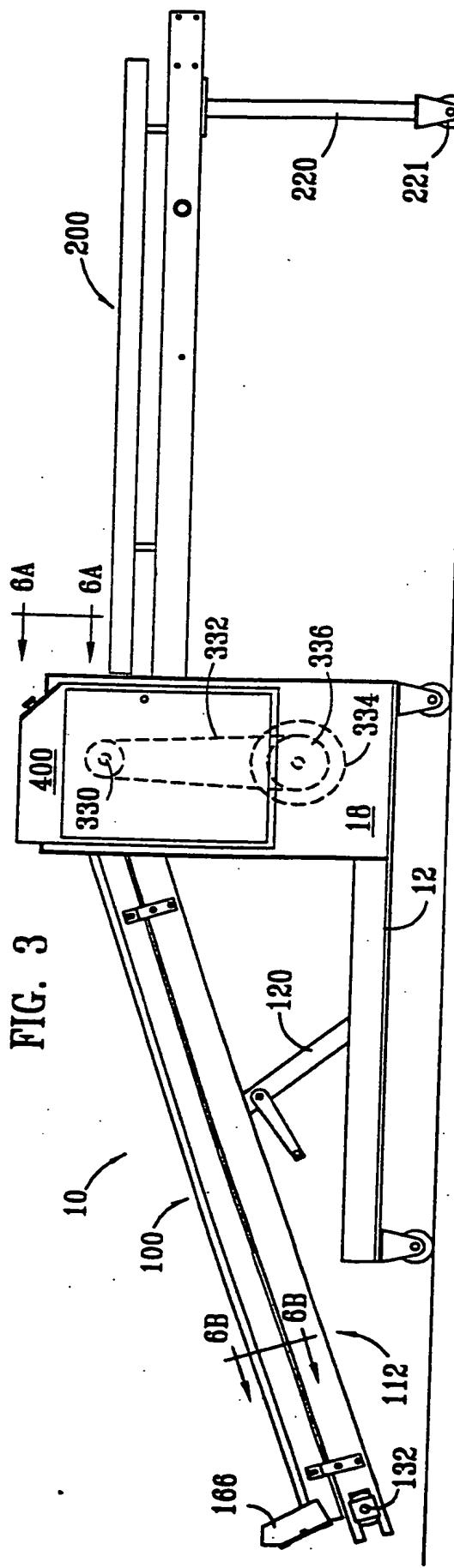


FIG. 6A

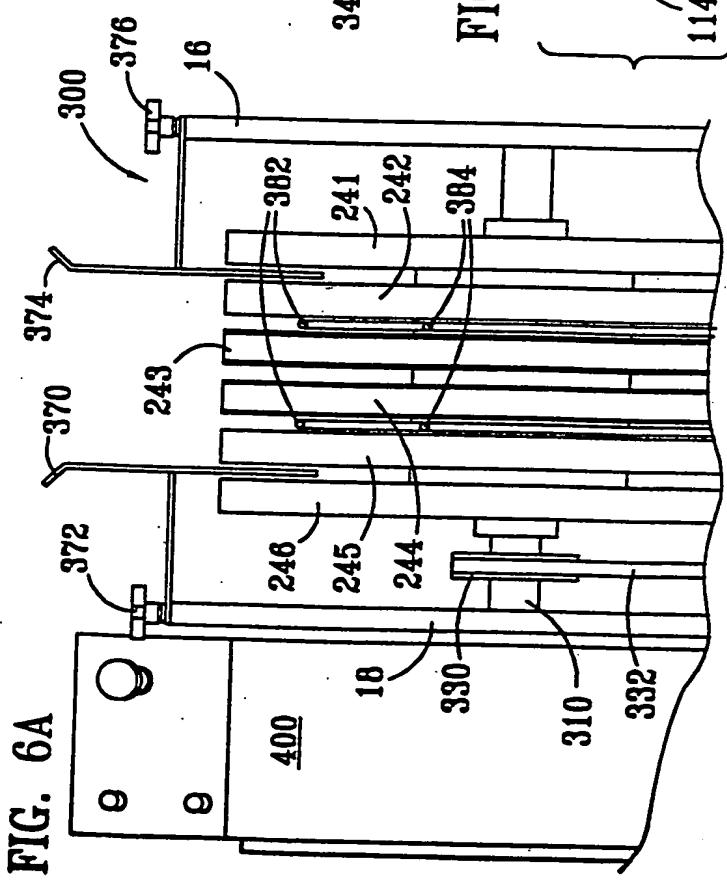


FIG. 7A

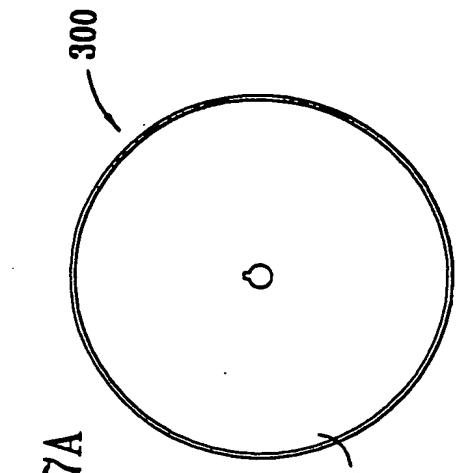
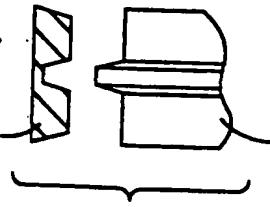


FIG. 7B  
144,142,145,146



341,342,345,346

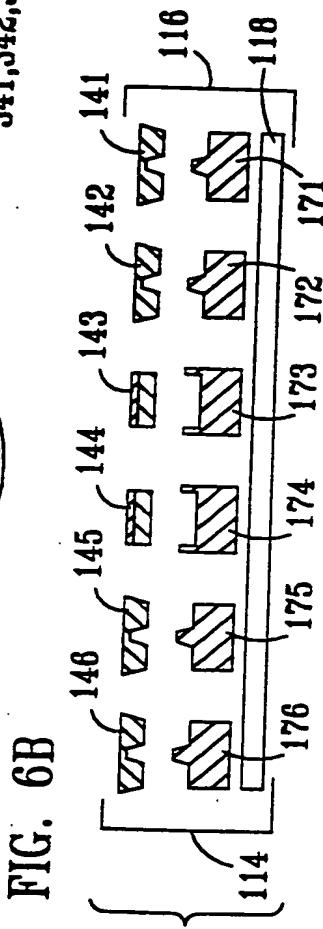


FIG. 4

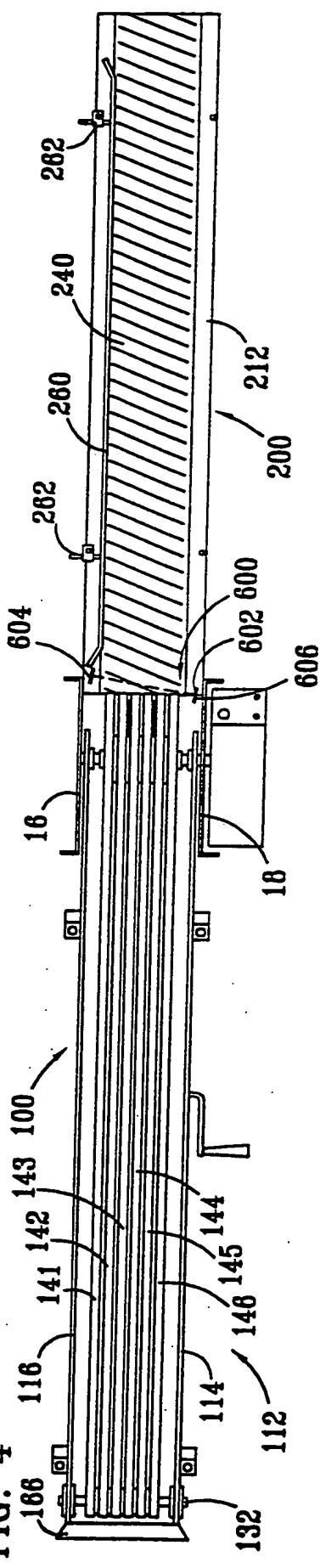
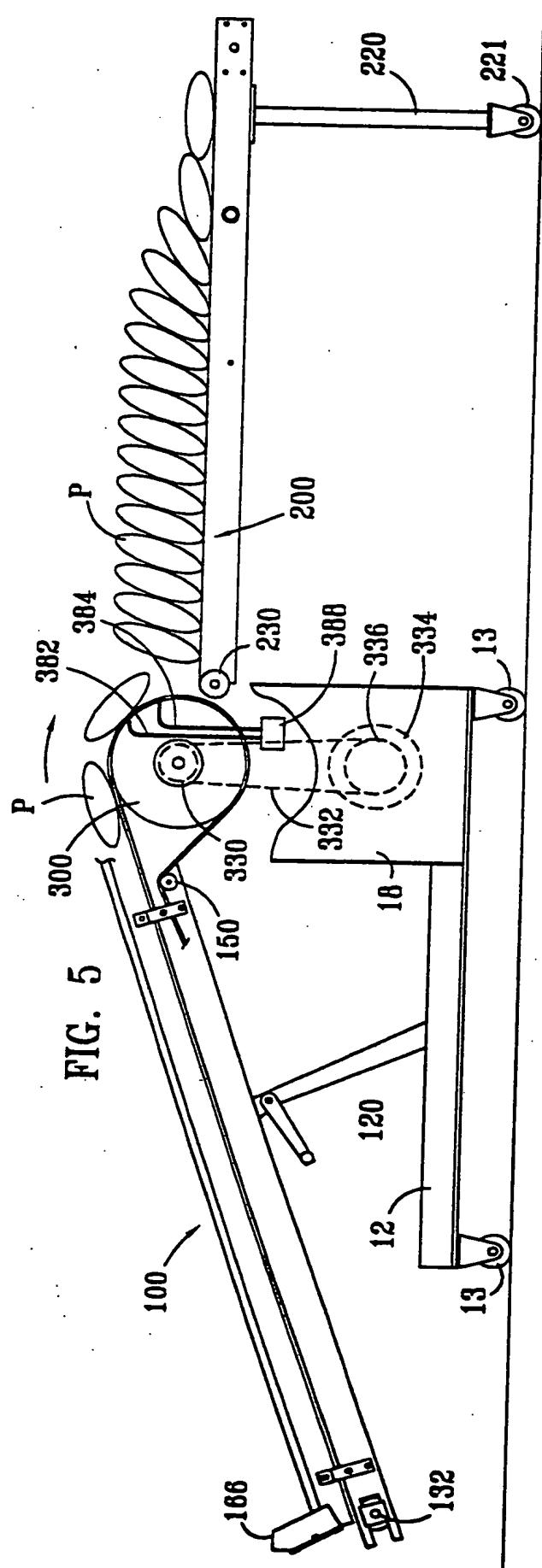
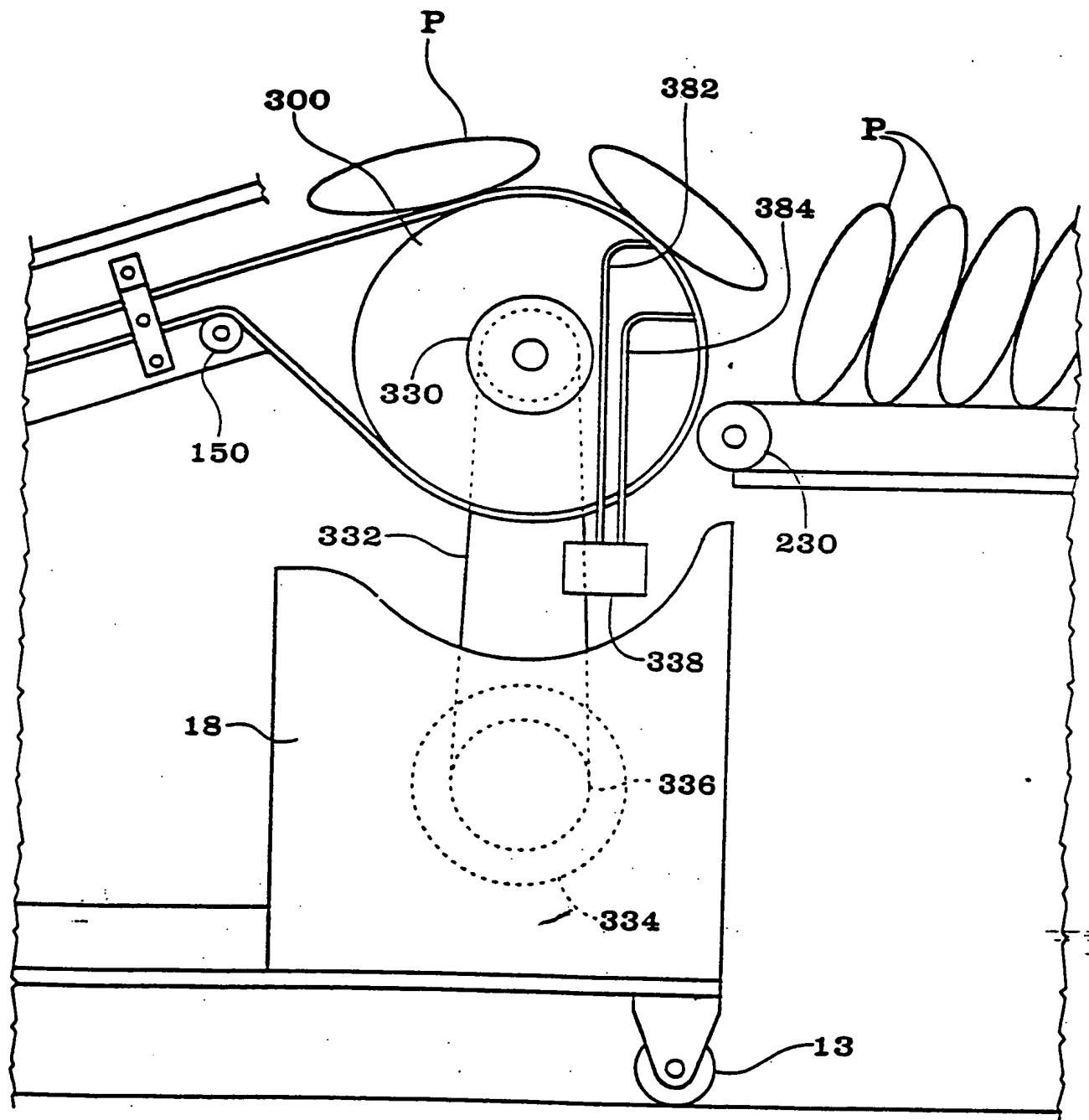


FIG. 5





**FIG.5A**

FIG. 7C

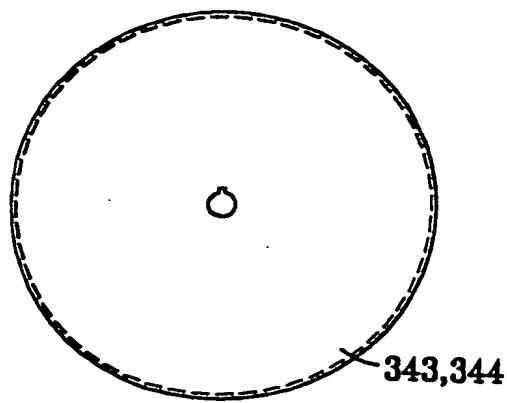


FIG. 7D

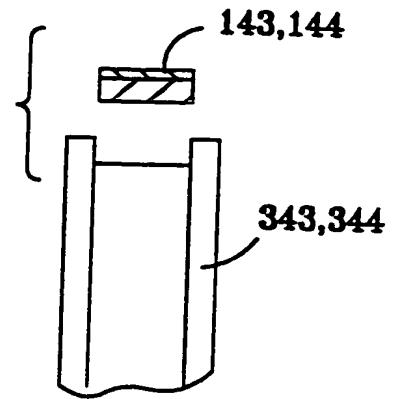


FIG. 8A

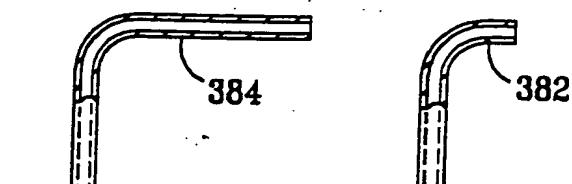


FIG. 8B

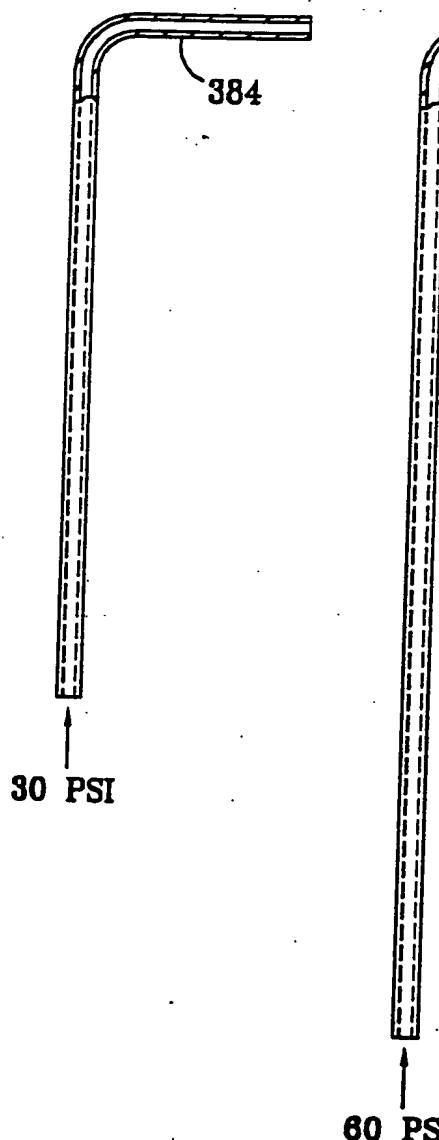


FIG. 9

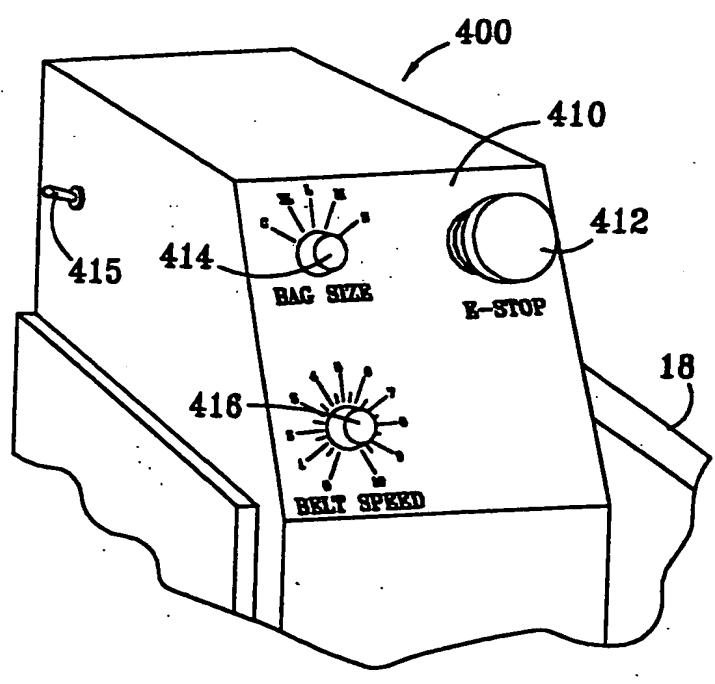


FIG. 10

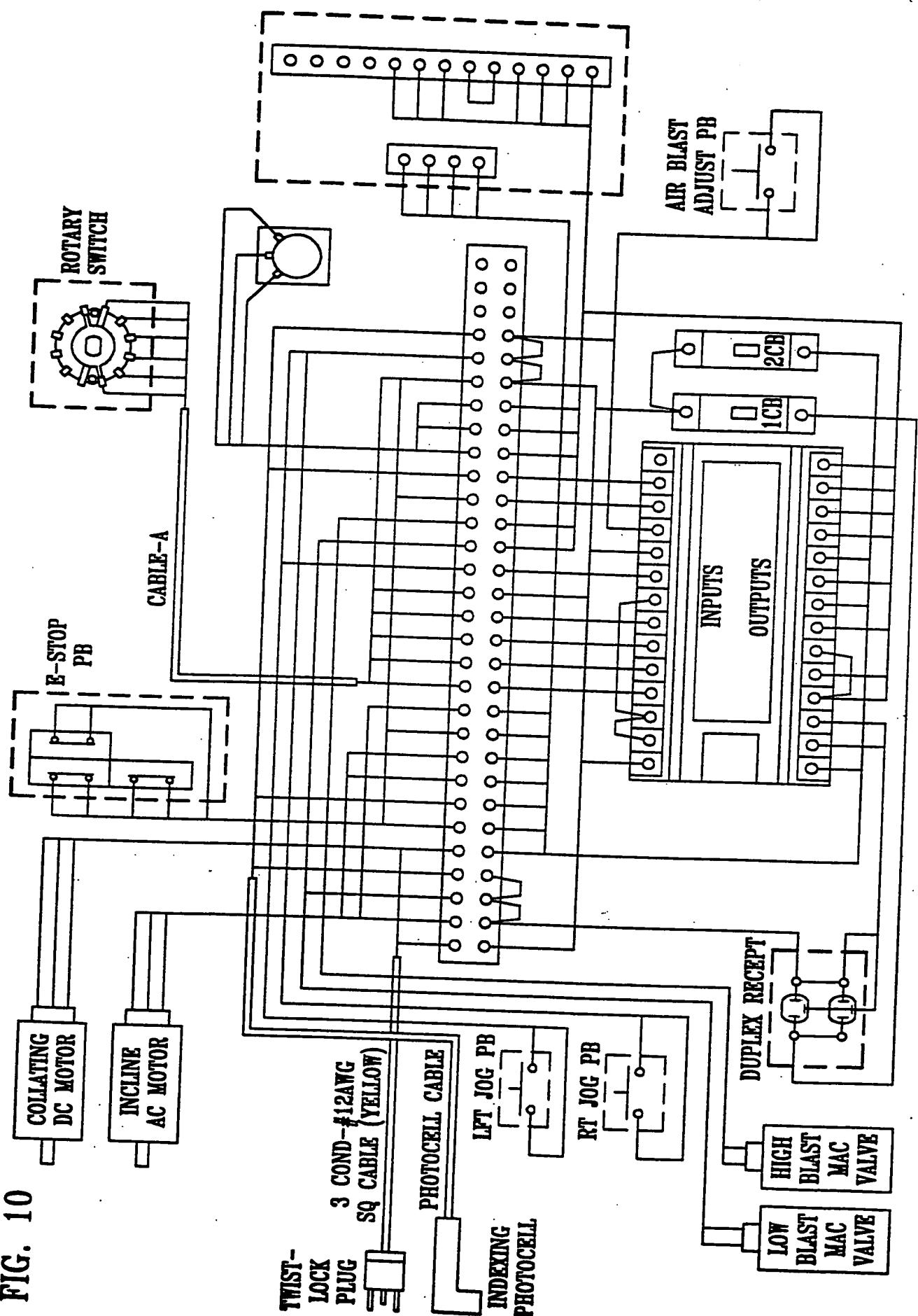


FIG. 11A

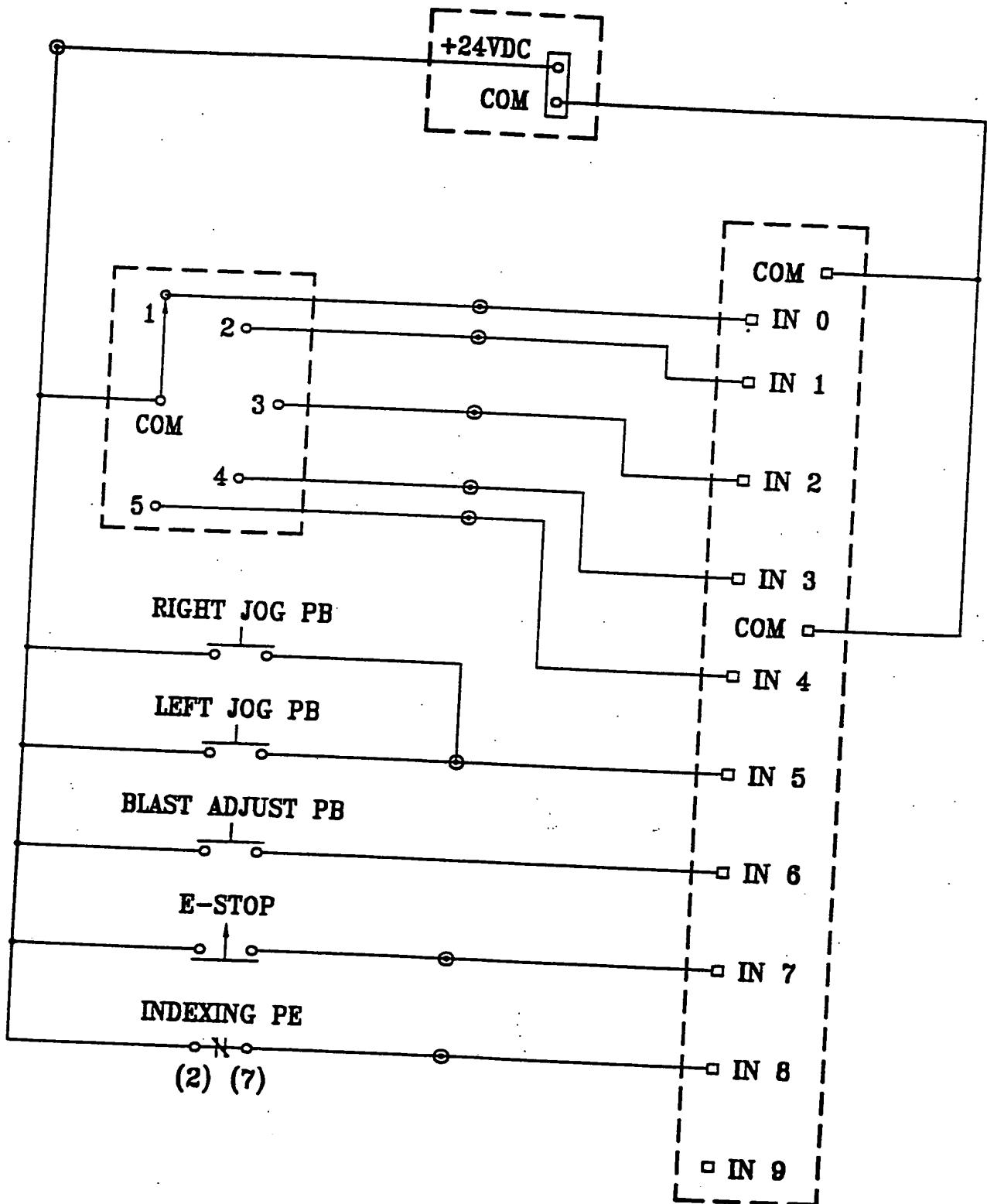
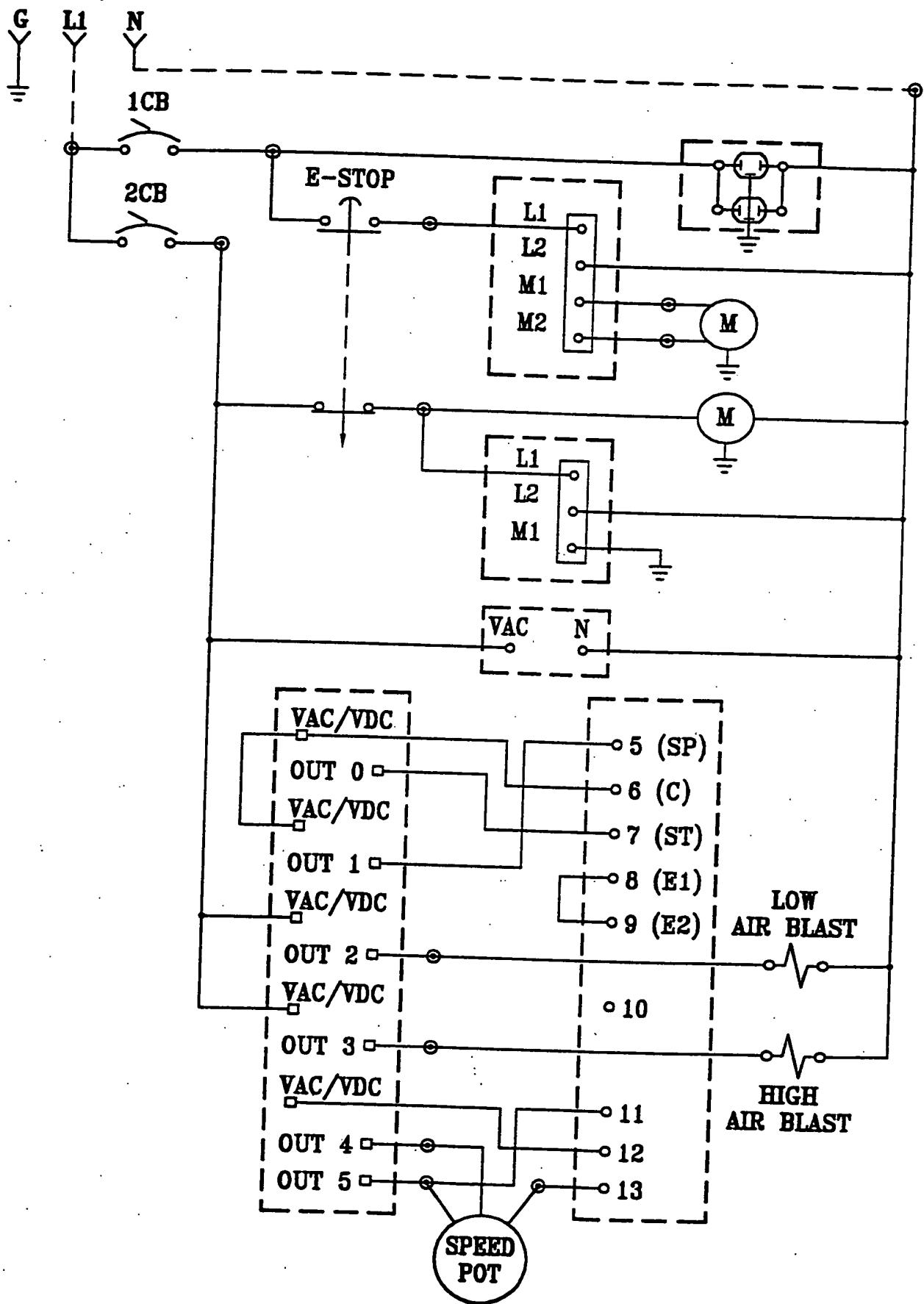


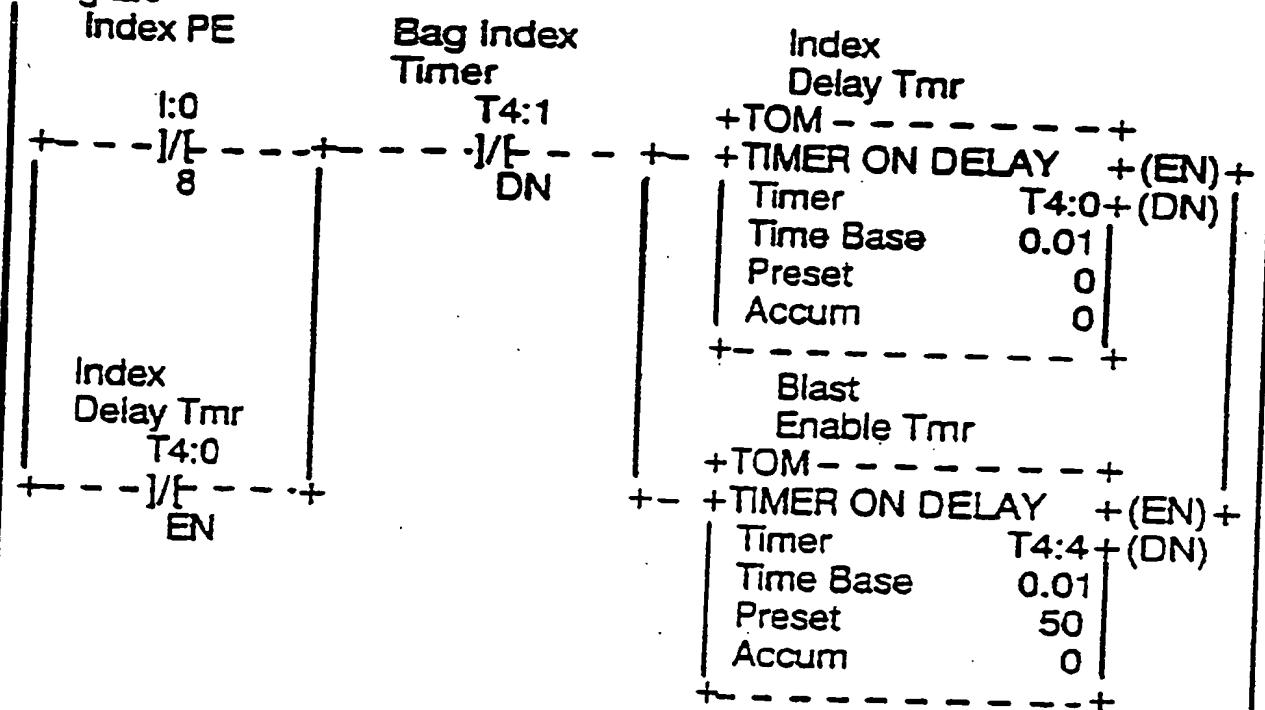
FIG. 11B

120V, 1PH, 60Hz

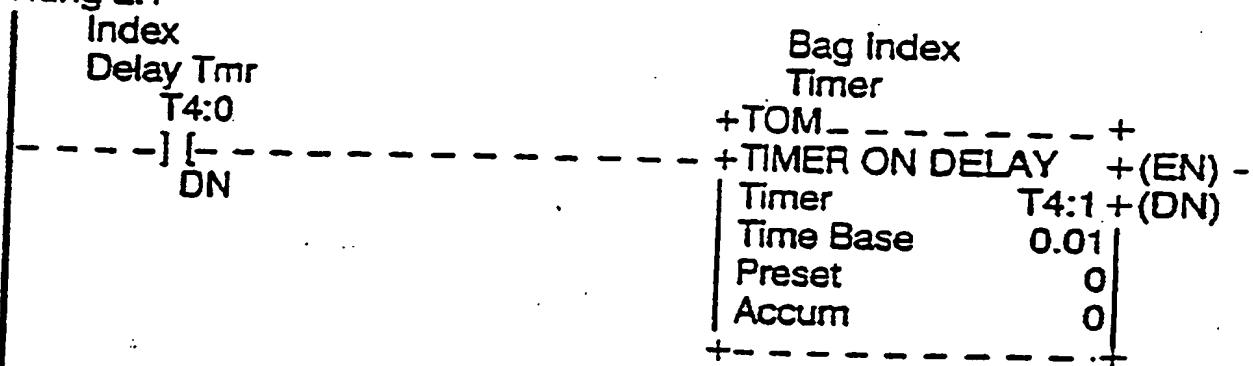


# AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:0



Rung 2:1



Rung 2:2

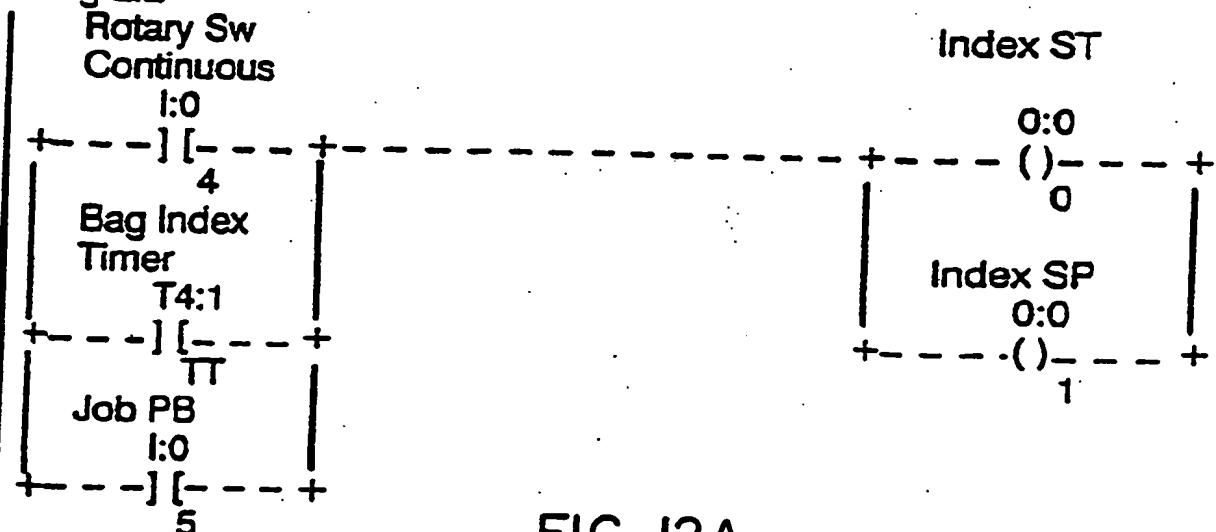


FIG. I2A

## AIR ASSISTED COLLATOR PROGRAM LISTING

## Rung 2:3

## Rung 2:4

Timing diagram showing the sequence of events for a rotary switch (Rotary Sw) and a blast timer (Blast Tmr). The diagram is divided into three main sections by vertical lines:

- Top Section:** Shows the signal for the **Med. Bag** (I:0). It starts with a low state, followed by a high state labeled **T4:4**, then a low state labeled **TT**, and finally a high state labeled **T4:5**.
- Middle Section:** Shows the signal for the **Blast Tmr**. It starts with a low state, followed by a high state labeled **TT**, then a low state labeled **T4:4**, and finally a high state labeled **TT**.
- Bottom Section:** Shows the signal for the **Med. Low Blast Tmr**. It starts with a low state, followed by a high state labeled **T4:5**, then a low state labeled **TT**, and finally a high state labeled **T4:4**.

The diagram uses a standard logic level representation where a solid line indicates a high state and a dashed line indicates a low state. The labels **TT** indicate a transition time.

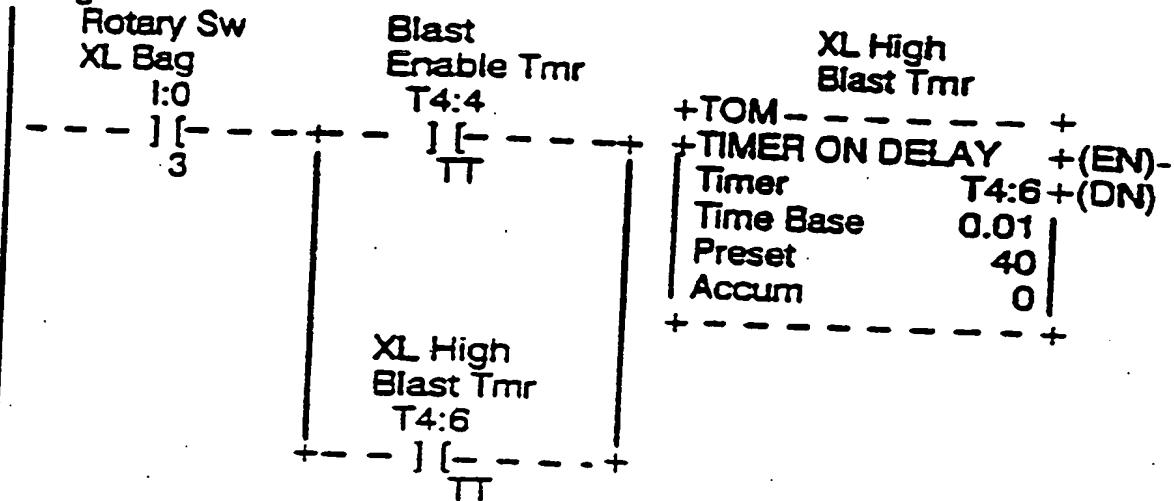
## Rung 2:5

Block diagram of a timer control system:

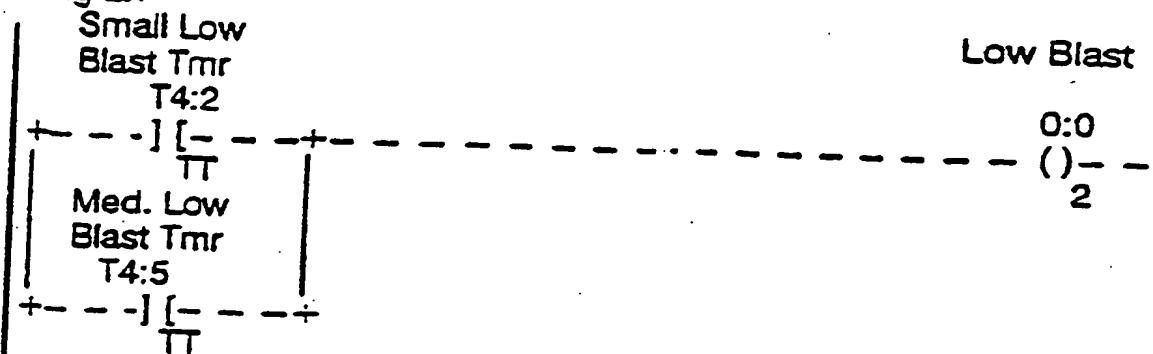
- Inputs:** Rotary Sw, Large Bag (labeled I:0)
- Block 1:** Blast Enable Tmr
  - Output to Large High Blast Tmr (labeled T4:3)
  - Output to TOM
- Block 2:** TOM
  - Output to Large High Blast Tmr (labeled T4:3+(DN))
  - Output to TIMER ON DELAY
- Block 3:** TIMER ON DELAY
  - Output to Timer (labeled T4:3+(DN))
  - Output to Time Base (labeled 0.01)
  - Output to Preset (labeled 30)
  - Output to Accum (labeled 0)
- Block 4:** Large High Blast Tmr (labeled T4:3+(DN))
- Block 5:** Large High Blast Tmr (labeled T4:3)

# AIR ASSISTED COLLATOR PROGRAM LISTING

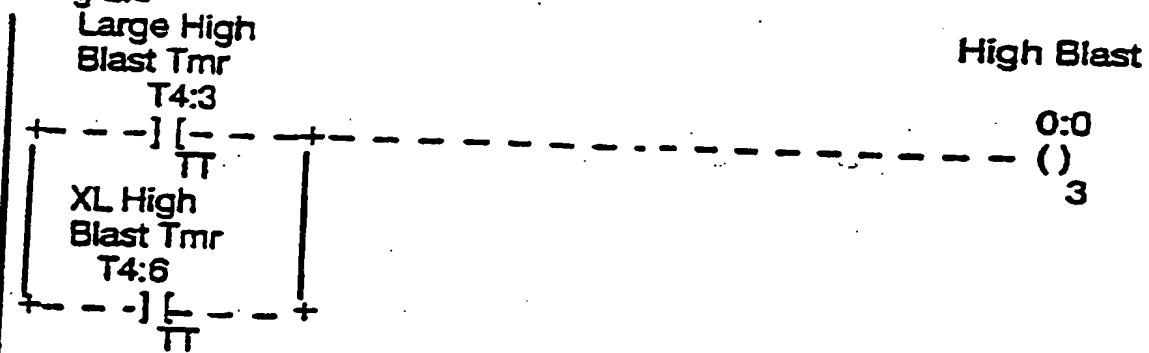
Rung 2:6



Rung 2:7



Rung 2:8



Rung 2:9

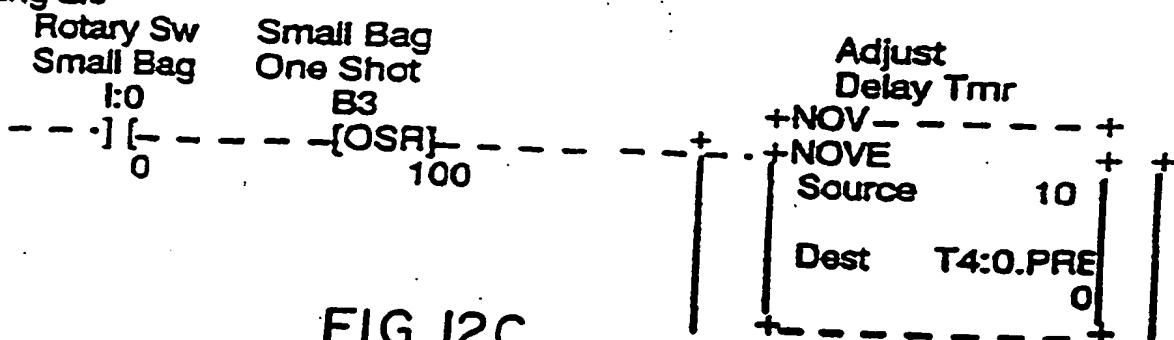
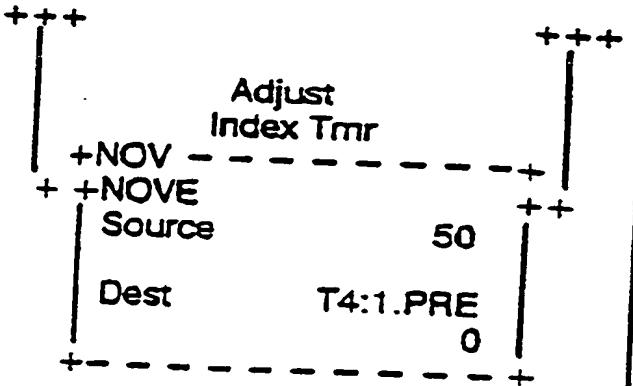
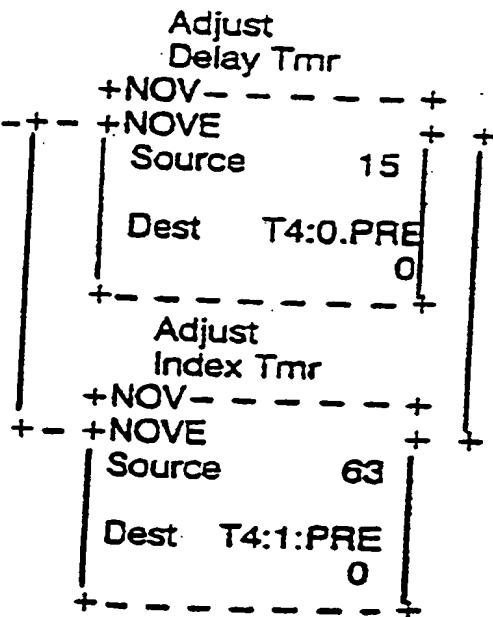
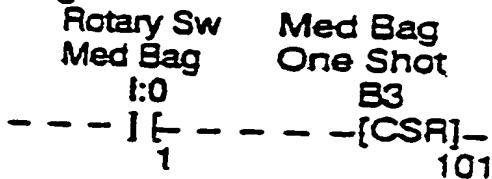


FIG. 12C

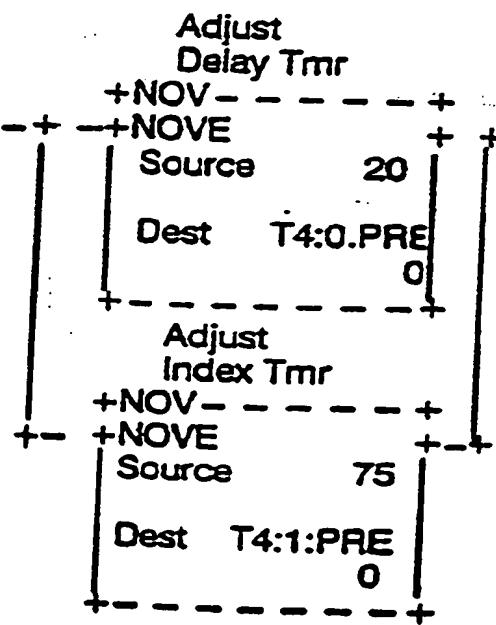
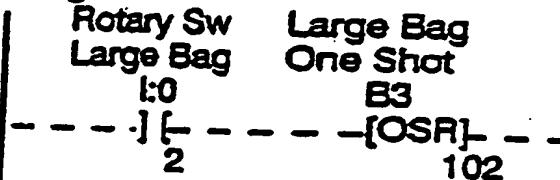
# AIR ASSISTED COLLATOR PROGRAM LISTING



Rung 2:10

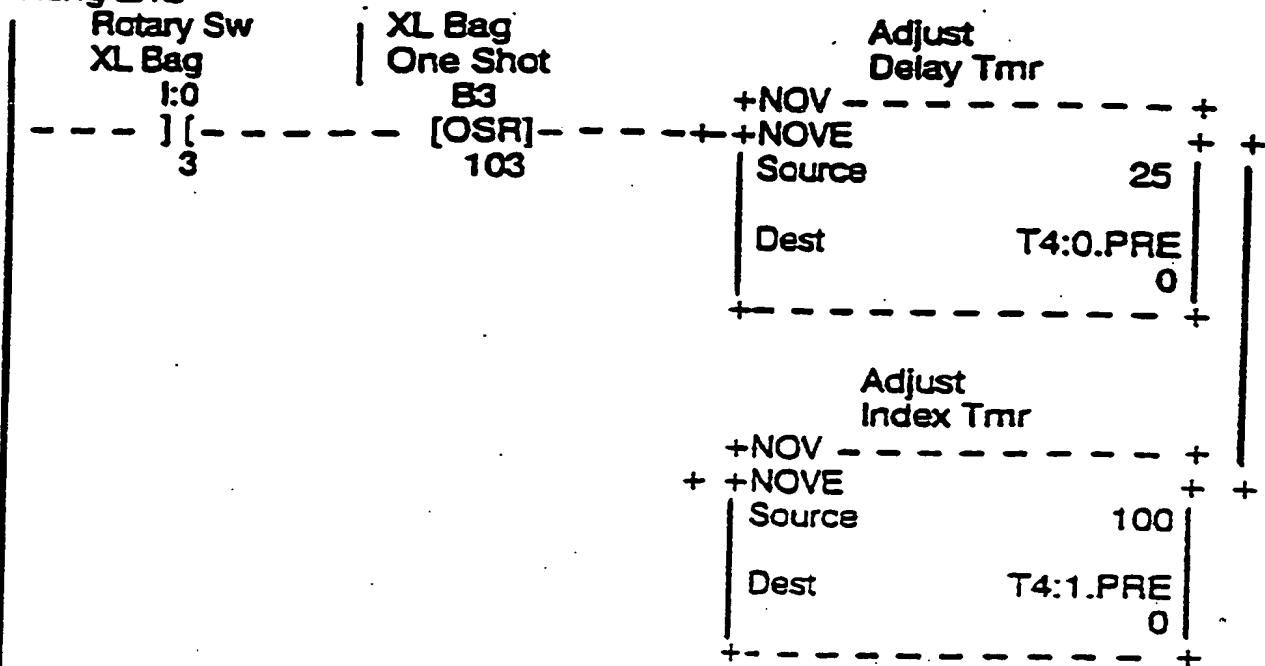


Rung 2:11

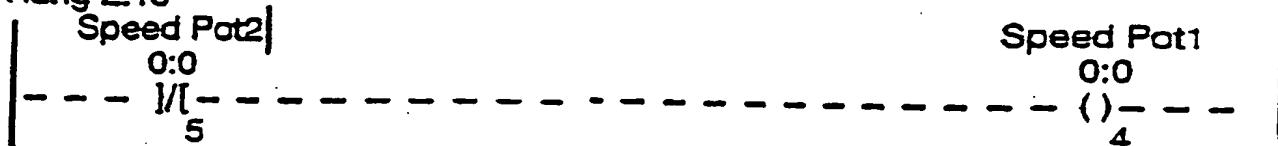


# AIR ASSISTED COLLATOR PROGRAM LISTING

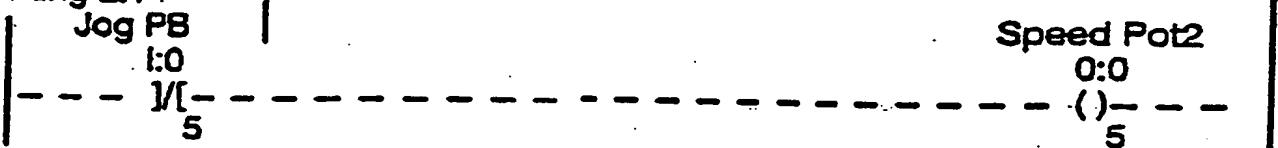
## Rung 2:12



## Rung 2:13



## Rung 2:14



## Rung 2:15

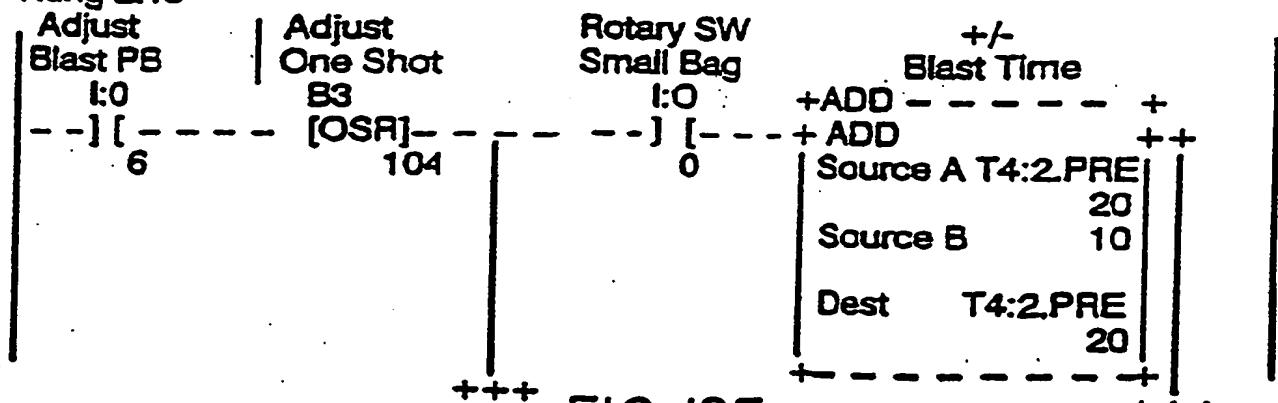
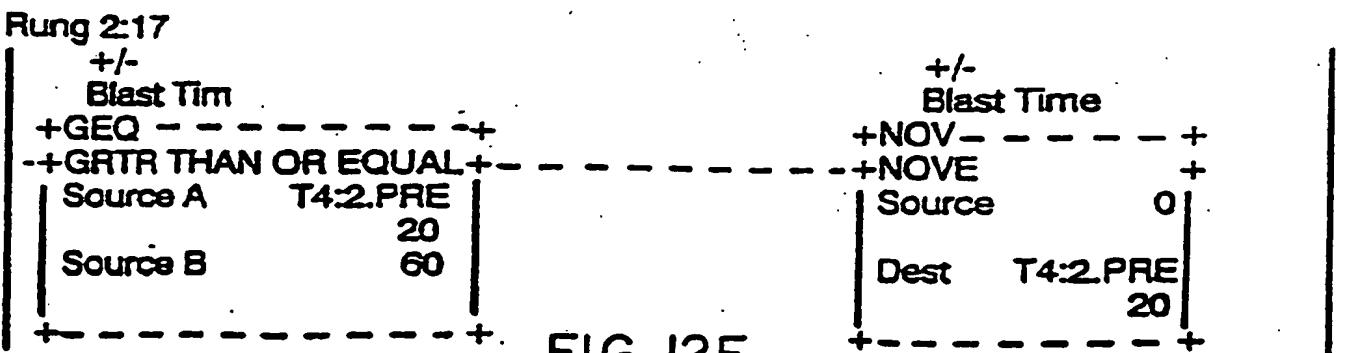
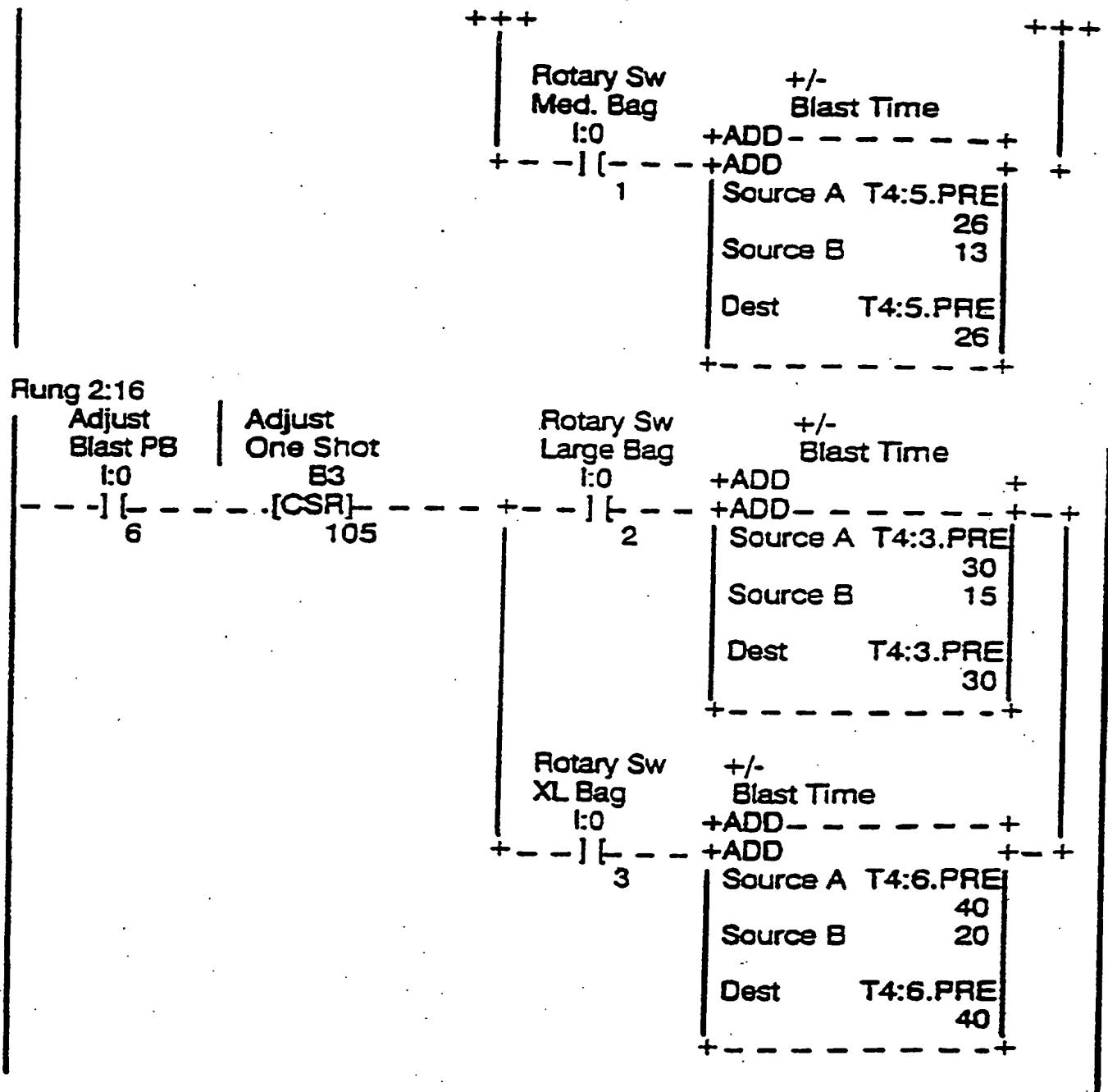


FIG. I2F

## AIR ASSISTED COLLATOR PROGRAM LISTING



## AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:18

+/-  
 Blast Time  
 +GEQ - - - - - +  
 +GRTR THAN OR EQUAL +  
 Source A T4:5.PRE  
 Source B 26  
 78

+/-  
 Blast Time  
 +NOV - - - - - +  
 +NOVE +  
 Source 0  
 Dest T4:5.PRE  
 26

Rung 2:19

+/-  
Blast Time  
+GEQ ----- +  
-+GRTR THAN OR EQUAL+  
Source A T4:3.PRE  
Source B 30  
90

+/-  
 Blast Time  
 +NOV - - - - - +  
 +NOVE +  
 Source 0  
 Dest T4:3.PRE  
 30

Rung 2:20

+/-  
Blast Time  
+GEO - - - - - - - - +  
-+GRTR THAN OR EQUAL+  
Source A T4:6.PRE  
Source B 40  
120

Runq 2:21

-----+END+-----  
FIG. 126

FIG. 12G

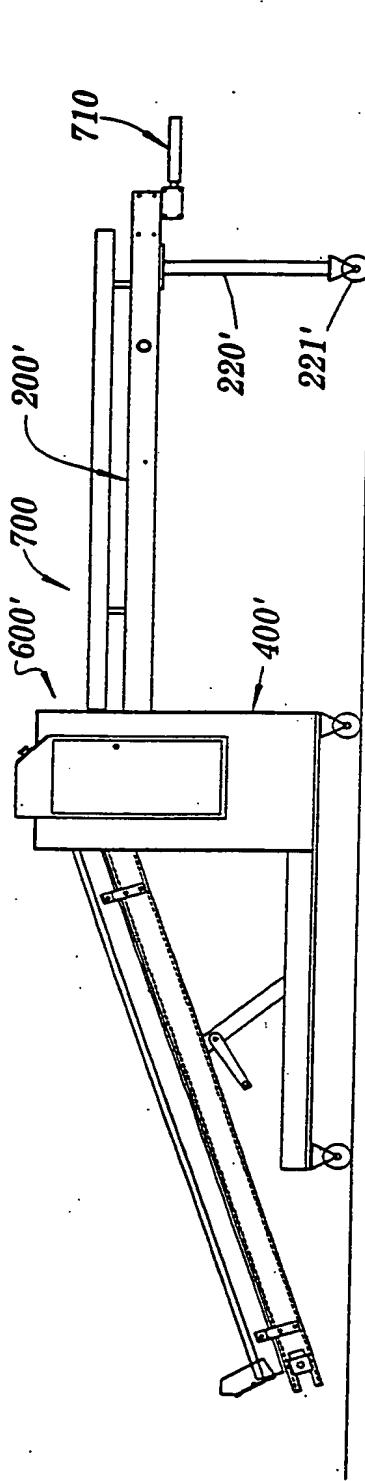


Fig. 13

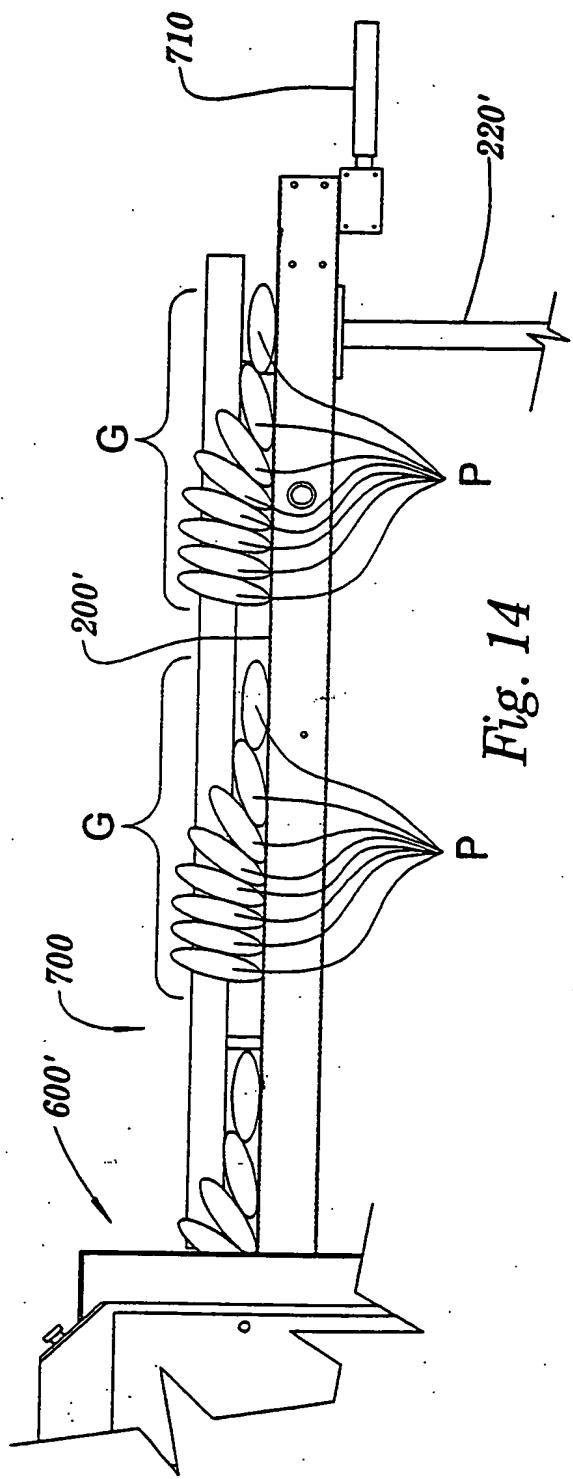
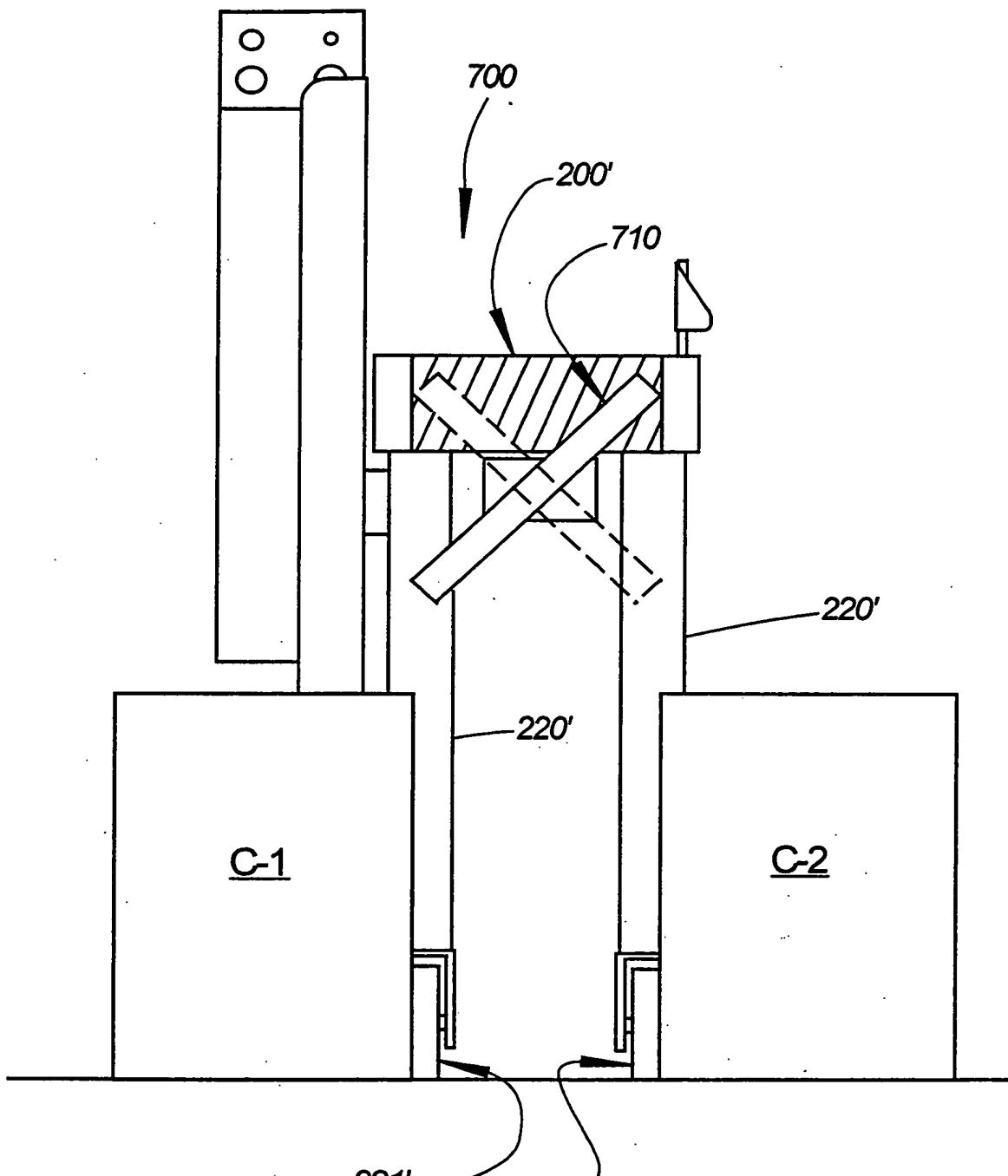


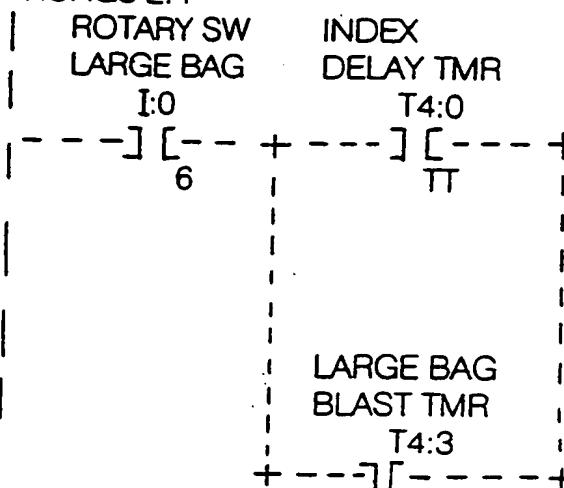
Fig. 14



*Fig. 15*

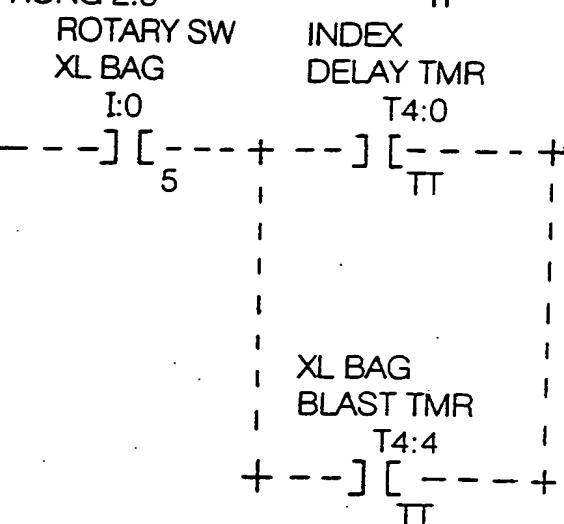


RUNGS 2:4



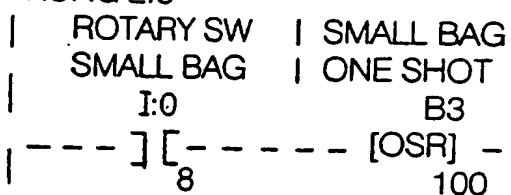
LARGE BAG  
BLAST TMR  
+ TON - - - - +  
+ TIMER ON DELAY + -(EN)  
|      TIMER      T4:3+ -(DN)  
|      TIME BASE   0.01  
|      PRESET      0  
|      ACCUM      0  
+ - - - - +

RUNG 2:5



XL BAG  
BLAST TMR  
+ TON - - - - +  
+ TIMER ON DELAY + -(EN)  
|      TIMER      T4:4+ -(DN)  
|      TIME BASE   0.01  
|      PRESET      0  
|      ACCUM      0  
+ - - - - +

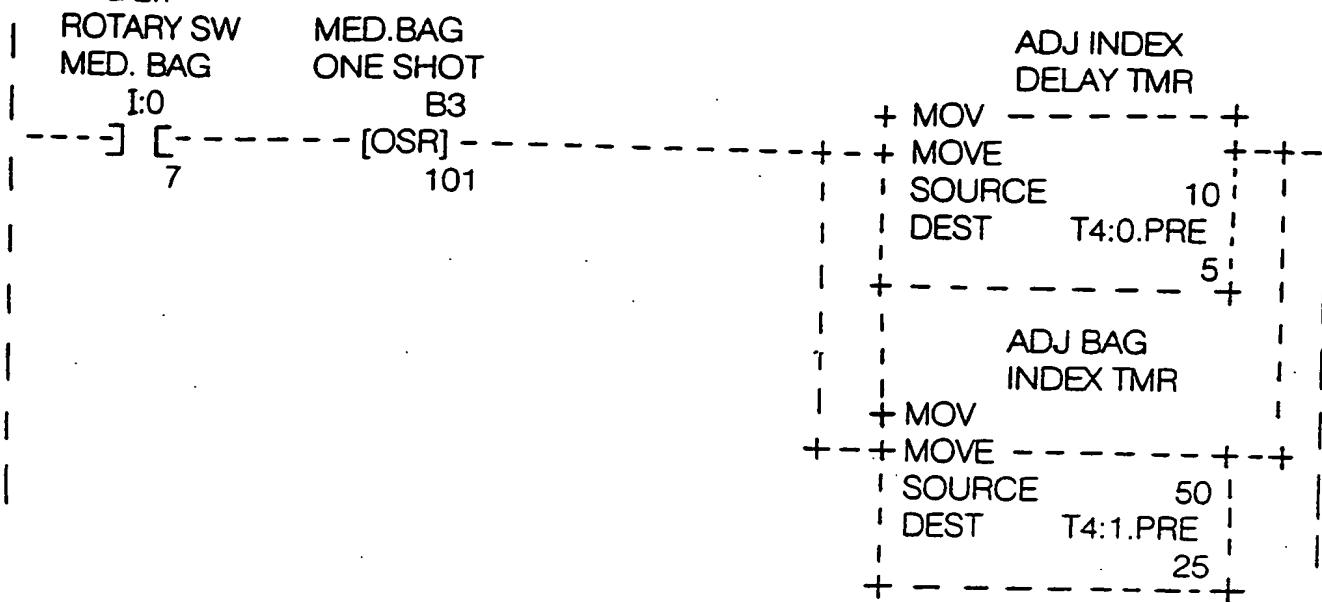
RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.  
RUNG 2:6



ADJ INDEX  
DELAY TMR  
+ MOV - - - - +  
+ MOVE      +-+  
|      SOURCE      5  
|      DEST      T4:0.PRE  
|      5  
+ - - - - +  
ADJ BAG  
INDEX TMR  
+ MOV - - - - +  
+ MOVE      +-+  
|      SOURCE      25  
|      DEST      T4:1.PRE  
|      25  
+ - - - - +

FIG.16B

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.  
RUNG 2:7



RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.  
RUNG 2:8

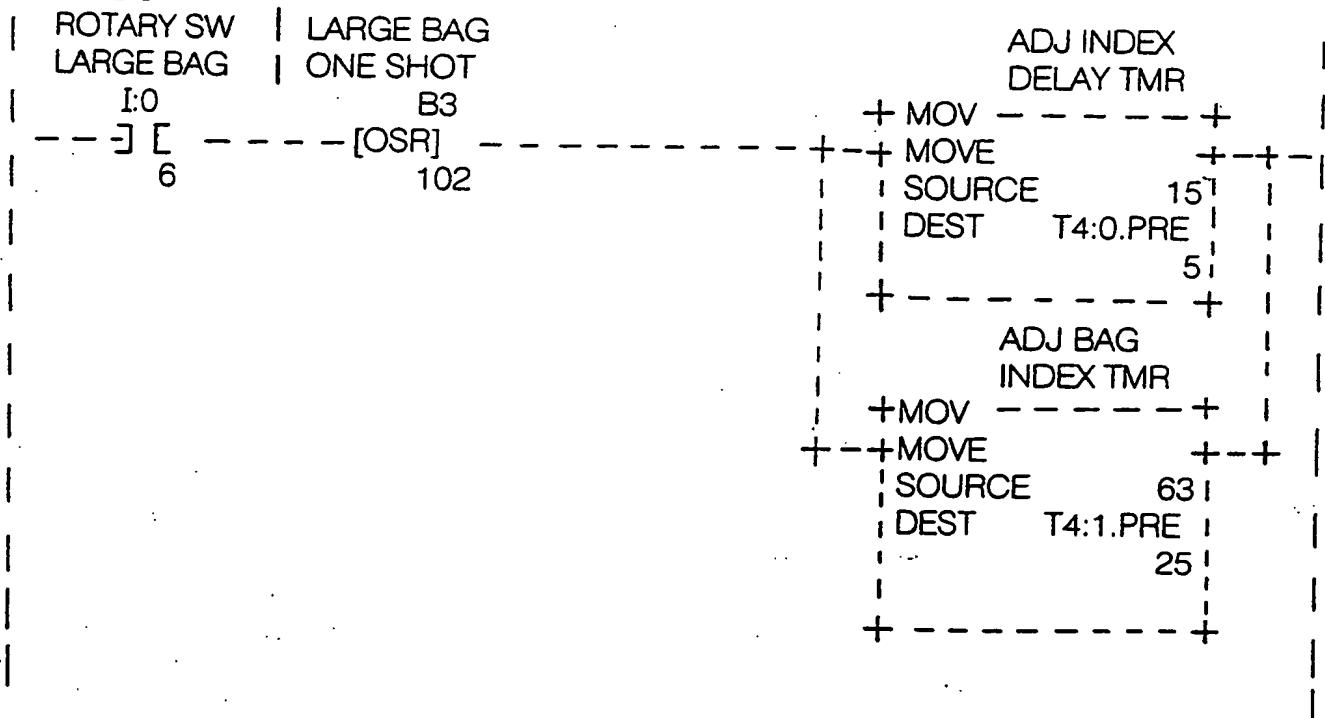
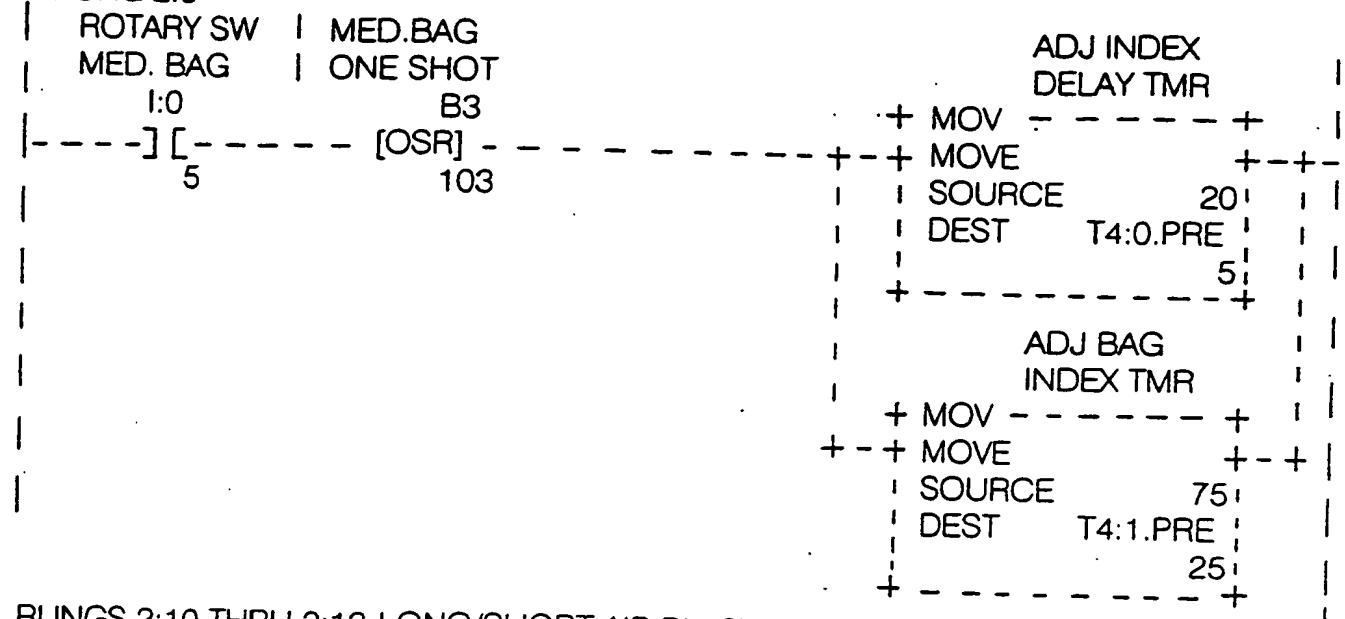
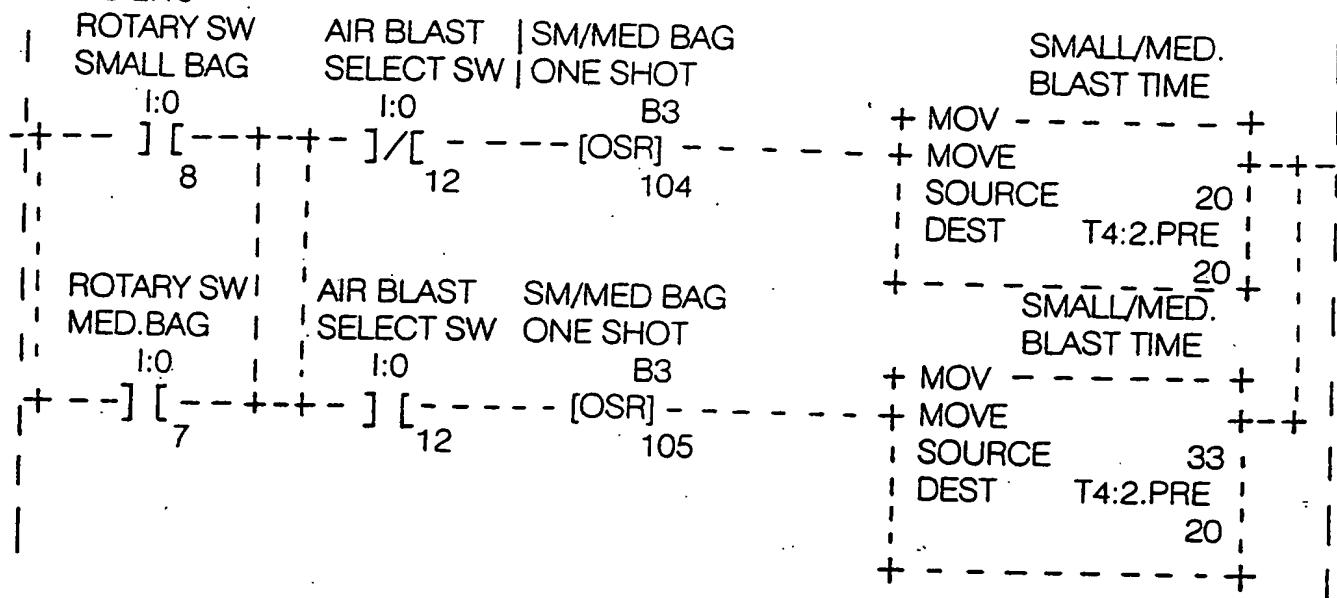


FIG. 16C

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.  
RUNG 2:9



RUNGS 2:10 THRU 2:12-LONG/SHORT AIR BLAST TIME CONTROLS.  
RUNG 2:10



RUNGS 2:11

ROTARY SW	AIR BLAST	LARGE BAG	LARGE BAG
LARGE BAG	SELECT SW	ONE SHOT	BLAST TIME
I:0	I:0	B3	+ MOV ----- +
6	12	106	+ MOVE
			SOURCE 33
			DEST T4:3.PRE
			0
			+-----+
	AIR BLAST	LARGE BAG	LARGE BAG
	SELECT SW	ONE SHOT	BLAST TIME
	I:0	B3	+ MOV ----- +
	+---] [----- [OSR]	107	+ MOVE
	12		SOURCE 50
			DEST T4:3.PRE
			0
			+-----+

RUNG 2:12

ROTARY SW	AIR BLAST	XL BAG	XL BAG
XL BAG	SELECT SW	ONE SHOT	BLAST TIME
I:0	I:0	B3	+ MOV ----- +
5	12	108	+ MOVE
			SOURCE 50
			DEST T4:4.PRE
			0
			+-----+
	AIR BLAST	XL BAG	XL BAG
	SELECT SW	ONE SHOT	BLAST TIME
	I:0	B3	+ MOV ----- +
	+---] [----- [OSR]	109	+ MOVE
	12		SOURCE 75
			DEST T4:4.PRE
			0
			+-----+

RUNGS 2:13 AND 2:14 - AIR BLAST SOLENOID CONTROLS.

RUNG 2:13

SMALL/MED.	LOW AIR
BLAST TMR	BLAST SOL.
T4:2	O:0
TT	( ) -----
	1

RUNGS 2:14

LARGE BAG

BLAST TMR

T4:3

HIGH AIR  
BLAST SOL.  
O:0

2

TT

XL BAG

BLAST TMR

T4:4

TT

RUNGS 2:15 THRU 2:22 - DC MOTOR SPEED CONTROLS.

RUNG 2:15

FULL/JOG BAG INDEX    PULLED GAP  
SPEED            TIMER            SPEED

INDEXING  
SPEED

O:0

T4:1

O:0

O:0

9

TT

10

8

RUNG 2:16

JOG PB'S

FULL/JOG  
SPEED

O:0

I:0

9

9

ROTARY SW

CONTINUOUS

I:0

+ - - ] [ - - - +

4

RUNG 2:17

ROTARY SW INDEXING | FULL/JOG | GAP TIMER |    PULLED GAP  
SMALL BAG SPEED | SPEED | |    SPEED

I:0

O:0

O:0

T4:5

O:0

8

8

9

TT

10

ROTARY SW

MED. BAG

I:0

+ - - ] [ - - +

7

ROTARY SW

LARGE BAG

I:0

+ - - ] [ - - +

6

ROTARY SW

XL BAG

I:0

+ - - ] [ - - +

5

FIG. 16F

RUNGS 2:18

ROTARY SW	SMALL BAG	GAP TIMER	
SMALL BAG	ONE SHOT		
I:0	B3		
[OSR]		+ MOV - - - - +	
8	110	+ MOVE	
		+ SOURCE 50	
		+ DEST T4:5.PRE	
		+ 50	
		+ - - - - - +	

RUNG 2:19

ROTARY SW	MED.BAG	GAP TIMER	
MED.BAG	ONE SHOT		
I:0	B3		
[OSR]		+ MOV - - - - +	
7	111	+ MOVE	
		+ SOURCE 63	
		+ DEST T4:5.PRE	
		+ 50	
		+ - - - - - +	

RUNG 2:20

ROTARY SW	LARGE BAG	GAP TIMER	
LARGE BAG	ONE SHOT		
I:0	B3		
[OSR]		+ MOV - - - - +	
6	112	+ MOVE	
		+ SOURCE 75	
		+ DEST T4:5.PRE	
		+ 50	
		+ - - - - - +	

RUNG 2:21

ROTARY SW	XL BAG	GAP TIMER	
XL BAG	ONE SHOT		
I:0	B3		
[OSR]		+ MOV - - - - +	
5	113	+ MOVE	
		+ SOURCE 100	
		+ DEST T4:5.PRE	
		+ 50	
		+ - - - - - +	

RUNG 2:22

COUNTER		GAP TIMER	
C5:1			
[DN]		+ TON +	
		+ TIMER ON DELAY +(EN)	
		+ TIMER T4:5+(DN)	
		+ TIME BASE 0.01	
		+ PRESET 50	
		+ ACCUM 0	
		+ - - - - - +	
GAP TIMER			
T4:5			
[TT]			

FIG. 16G

RUNGS 2:23 THRU 2:28 - OPTIONAL LOOSE PACK CONTROLS.

RUNG 2:23

RUNG 2:24

RUNG 2:25

BLING 2:26

1100 2.20  
| SWITCH DEL | LOOSE PACK  
| TIMER #1 | DIVERTER  
| T4:6 | O:0  
|-----] [----- (L)-----  
| DN | 3

FIG. 16H

## RUNGS 2:27

LOOSE PACK OSCILLATOR	SWITCH DEL TIMER #2	LOOSE PACK OSCILLATOR
+ EQU ----- +	T4:7	+ MOV ----- +
-++ + EQUAL	+ - + -]/[----- +	MOVE
SOURCE A C5:0.ACC	DN	SOURCE 0
0		
SOURCE B	2	DEST C5:0.ACC
		0
+----- +		+----- +
SWITCH DEL		SWITCH DEL
TIMER #2		TIMER #2
T4:7		+ TON ----- +
+--- ] [----- +		+--+ TIMER ON DELAY +-(EN)-+
EN		TIMER T4:7+- (DN)
		TIME BASE 0.01
		PRESET 50
		ACCUM 0
	+----- +	+----- +

RUNG 2:28

SWITCH DEL | LOOSE PACK  
TIMER #2 | DIVERTER  
T4:7 O:0  
---] [----- (U) -----  
DN 3

RUNGS 2:29 THRU 2:32-STROBE CONTROLS. THE OUTPUTS WILL STROBE ONCE WHENEVER THE START BUTTON IS PRESSED, OR WHEN THE COUNTER REACHES IT'S COUNT. THIS WILL LOAD THE VALUE ONTHE THUMBWHEEL SWITCHES INTO MEMORY. RUNG 2:29

RUNG 2:29

FIG. 161

## RUNG 2:30

START

B3

21

COUNTER

C5:1

DN

1'S COUNT

TIMER

T4:8

TT

## RUNG 2:31

1'S COUNT

TIMER

T4:8

T4:8

10'S COUNT

TIMER

T4:9

TT

## RUNG 2:32

10'S COUNT

TIMER

T4:9

T4:9

DN

100'S

COUNT TMR

T4:10

TT

1'S COUNT  
TIMER

+TON

+--+TIMER ON DELAY+- (EN) -+-

+--+TIMER T4:8+ - (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - +

1'S COUNT

O:0

+ - - ( ) - - - - - +

4

10'S COUNT  
TIMER

+TON

+--+TIMER ON DELAY+- (EN) -+-

| TIMER T4:9+ - (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - +

10'S COUNT

O:0

+ - - ( ) - - - - - +

5

100'S  
COUNT TMR

+TON

+--+TIMER ON DELAY+- (EN) -+-

| TIMER T4:10+ - (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - +

100'S  
COUNT

O:0

+ - - ( ) - - - - - +

6

FIG. 16J

RUNGS 2:33 THRU 2:42-NUMBER CONTROL FOR ALL THUMBWHEEL SWITCHES.

RUNG 2:33

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	ZERO
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	10

RUNG 2:34

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	ONE
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	11

RUNG 2:35

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	TWO
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	12

RUNG 2:36

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	THREE
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	13

RUNG 2:37

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	FOUR
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	14

RUNG 2:38

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	FIVE
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	15

RUNG 2:39

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	SIX
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	16

RUNG 2:40

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	SEVEN
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	17

RUNG 2:41

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	EIGHT
I:0	I:0	I:0	I:0	
---]/[-----]/[-----]/[-----]/[-----				B3
0	1	2	3	18

RUNGS 2:42

1 1'S STROBE 2'S STROBE 4'S STROBE 8'S STROBE NINE  
 I:0 I:0 I:0 I:0 B3  
 - - - ] [ - - - ] / [ - - - ] / [ - - - ] [ - - - - - ( ) - - -  
 0 1 2 3 19

RUNGS 2:43 THRU 2:47-EVALUATE THUMBWHEEL SETTINGS AND LOAD VALUE INTO N7:0.

RUNG 2:43

1'S COUNT	ZERO	I'S PLACE
O:0	B3	+MOV - - - +
- - - ] [ - - - - - + - - ] [ - - - + MOVE	10	+--+-
4	I SOURCE	0
	I DEST	N7:1
		3
	+ - - - - +	
ONE		1'S PLACE
B3	+MOV - - - +	
+ - - - ] [ - - - - + MOVE	11	+--+-
	I SOURCE	1
	I DEST	N7:1
		3
	+ - - - - +	
TWO		1'S PLACE
B3	+MOV - - - +	
+ - - - ] [ - - - - + MOVE	12	+--+-
	I SOURCE	2
	I DEST	N7:1
		3
	+ - - - - +	
THREE		1'S PLACE
B3	+MOV - - - +	
+ - - - ] [ - - - - + MOVE	13	+--+-
	I SOURCE	3
	I DEST	N7:1
		3
	+ - - - - +	
FOUR		1'S PLACE
B3	+MOV - - - +	
+ - - - ] [ - - - - + MOVE	14	+--+-
	I SOURCE	4
	I DEST	N7:1
		3
	+ - - - - +	
FIVE		1'S PLACE
B3	+MOV - - - +	
+ - - - ] [ - - - - + MOVE	15	+--+-
	I SOURCE	5
	I DEST	N7:1
		3
	+ - - - - +	

+++

+++

FIG. 16L

```

+++          +++
| SIX          1'S PLACE
|   B3      + MOV - - - - - + - +
+ - -] [--- + MOVE
|   16      | SOURCE      6
|           | DEST        N7:1
|           |             3
|           + - - - - - - + - +
| SEVEN        1'S PLACE
|   B3      + MOV - - - - - + - +
+ - -] [--- + MOVE
|   17      | SOURCE      7
|           | DEST        N7:1
|           |             3
|           + - - - - - - + - +
| EIGHT        1'S PLACE
|   B3      + MOV - - - - - + - +
+ - -] [--- + MOVE
|   18      | SOURCE      8
|           | DEST        N7:1
|           |             3
|           + - - - - - - + - +
| NINE          1'S PLACE
|   B3      + MOV - - - - - + - +
+ - -] [--- + MOVE
|   19      | SOURCE      9
|           | DEST        N7:1
|           |             3
|           + - - - - - - + - +

```

RUNG 2:44

FIG. 16M

```

+++++
|           TWO          10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           12 | SOURCE      2
|           | DEST        N7:2
|           |           0
|           +-----+
|           THREE         10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           13 | SOURCE      3
|           | DEST        N7:2
|           |           0
|           +-----+
|           FOUR          10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           14 | SOURCE      4
|           | DEST        N7:2
|           |           0
|           +-----+
|           FIVE          10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           15 | SOURCE      5
|           | DEST        N7:2
|           |           0
|           +-----+
|           SIX           10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           16 | SOURCE      6
|           | DEST        N7:2
|           |           0
|           +-----+
|           SEVEN         10'S PLACE
|           B3 + MOV -----+
|           +---] [---+ MOVE
|           17 | SOURCE      7
|           | DEST        N7:2
|           |           0
|           +-----+
+++++

```

FIG. 16N

RUNG 2:45

100'S COUNT	ZERO	100'S PLACE
O:0	B3	+MOV --- +
-----] [-+ -+ - -]	[- -	+MOVE
6	10	SOURCE 0
		DEST N7:4
		0
		+ - - - - +
	ONE	100'S
		PLACE
	B3	+MOV --- +
+ - -] [- -	[- -	+MOVE
11	SOURCE 1	
	DEST N7:4	
	0	
	+ - - - - +	
+++++		+++

FIG. 160

+ + + + +		+ + +		+ + +
	TWO		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		12   SOURCE 2		
		DEST N7:4		
		0		
		+ - - - - - - - - +		
	THREE		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		13   SOURCE 3		
		DEST N7:4		
		0		
		+ - - - - - - - - +		
	FOUR		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		14   SOURCE 4		
		DEST N7:4		
		0		
		+ - - - - - - - - +		
	FIVE		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		15   SOURCE 5		
		DEST N7:4		
		0		
		+ - - - - - - - - +		
	SIX		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		16   SOURCE 6		
		DEST N7:4		
		0		
		+ - - - - - - - - +		
	SEVEN		100'S PLACE	
		B3 + MOV - - - - - +		
		+ - - - - [ - + MOVE		
		17   SOURCE 7		
		DEST N7:4		
		0		
		+ - - - - - - - - +		

+++

FIG 16D

+++

FIG. 16Q

RUNG 2:47

100'S  
COUNT TMR  
T4:10

## ADD TOTAL TO 100'S

RUNGS 2:48 THRU 2:50 COUNTER CONTROLS THE COUNTER IS RESET EVERY TIME IT REACHES IT'S COUNT, AND RELOADS THE THUMBWHEEL VALUE. THIS HAPPENS ALSO WHEN THE START BUTTON IS PRESSED.

RUNG 2:48

ADD TOTAL  
TO 100'S

+ EQ - - - - - +  
- + EQUAL +  
| SOURCE A N7:0 |  
| 3 |  
| SOURCE B 0 |  
+ - - - - - +

```

+ ADD - - - - - +  

+ ADD + - +  

| SOURCE A N7:6 |  

| | 3 |  

| SOURCE B N7:4 |  

| | 0 |  

| DEST N7:0 |  

+ - - - - - 3 +  

+ MOV - - - - - +  

+ MOVE + - +  

| SOURCE N7:0 |  

| DEST C5:1.PRE |  

| | 3 |  

+ - - - - - +  


```

RUNG 2:49

## COUNTER

C5:1

- + - - ] [ -  
| DN  
| START PB  
| I:0  
+ - - ] [ - -  
11

## COUNTER

G5.1

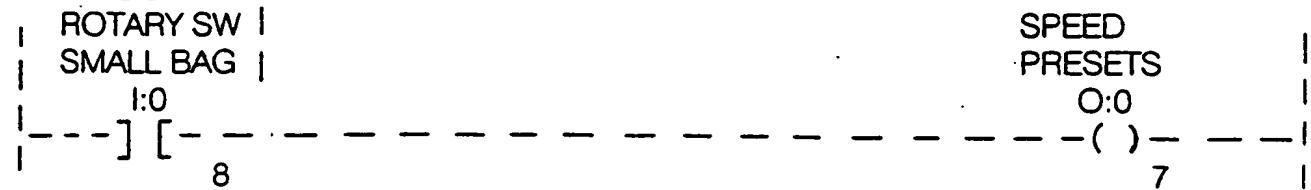
RUNG 2:50

INDEX ROTARY SW COUNT SET CONV RUN COUNTER COUNTER  
PHOTOCELL CONTINUOUS AT ZERO ONE SHOT

I:0	I:0	B3	B3	B3	+ CTU	---	+
[- - - - -]/[- - - - -]/[--- + - -]/[---]	13	4	1	0	[- - [OSR]	- + COUNT UP	+ -(CU) -
					116	COUNTER	C5:1+-(DN)
						PRESET	31
						ACCUM	0
						---	+
LOOSE PACK	ROTARY SW						
PHOTOCELL	CONTINUOUS						
I:0	I:0						
[- - - - -]/[ - - - - -]	[ - - +						
14	4						

RUNG 2:51-CONTROLS THE SELECTION OF VFD SPEED PRESETS. THE VFD WILL RUN AT SPEED PRESET #1 WHEN OUTPUT 7 IS LOW. SPEED PRESET #2 IS FOR SMALL BAGS. IF CONTINUOUS BAGS IS SELECTED, THE VFD WILL RUN AT A THIRD PRESET SPEED.

RUNG 2:51



RUNG 2:52

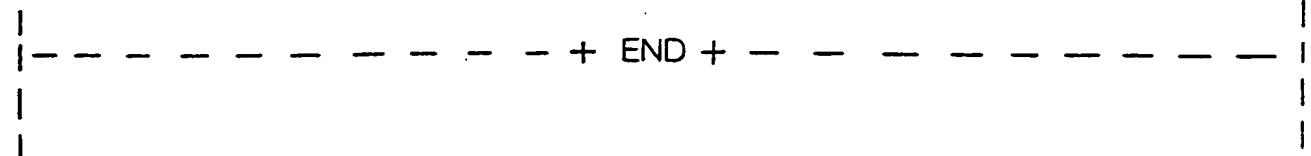


FIG. 16S

120VAC, 1 Ph, 60 Hz  
25 AMP POWER CORD

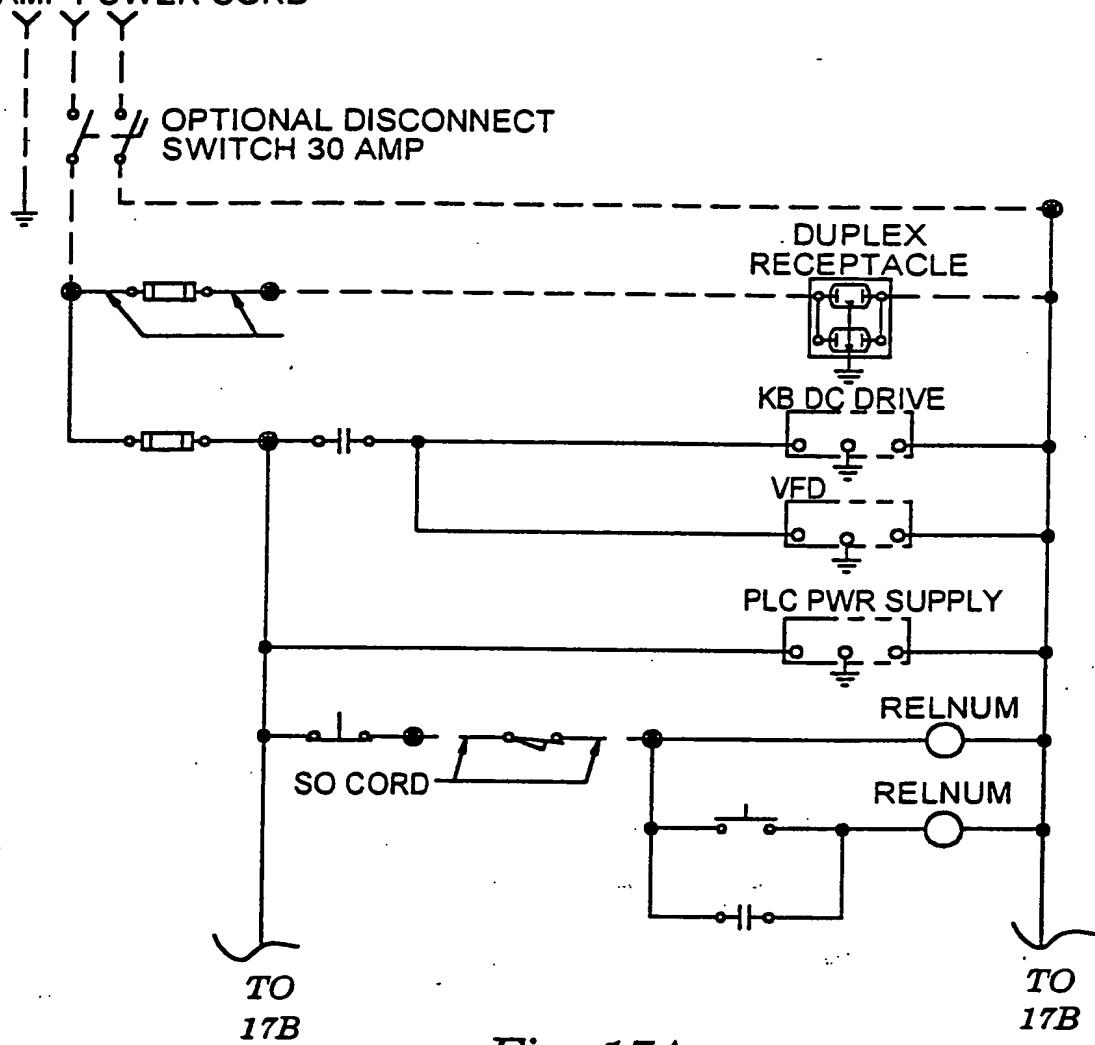


Fig. 17A

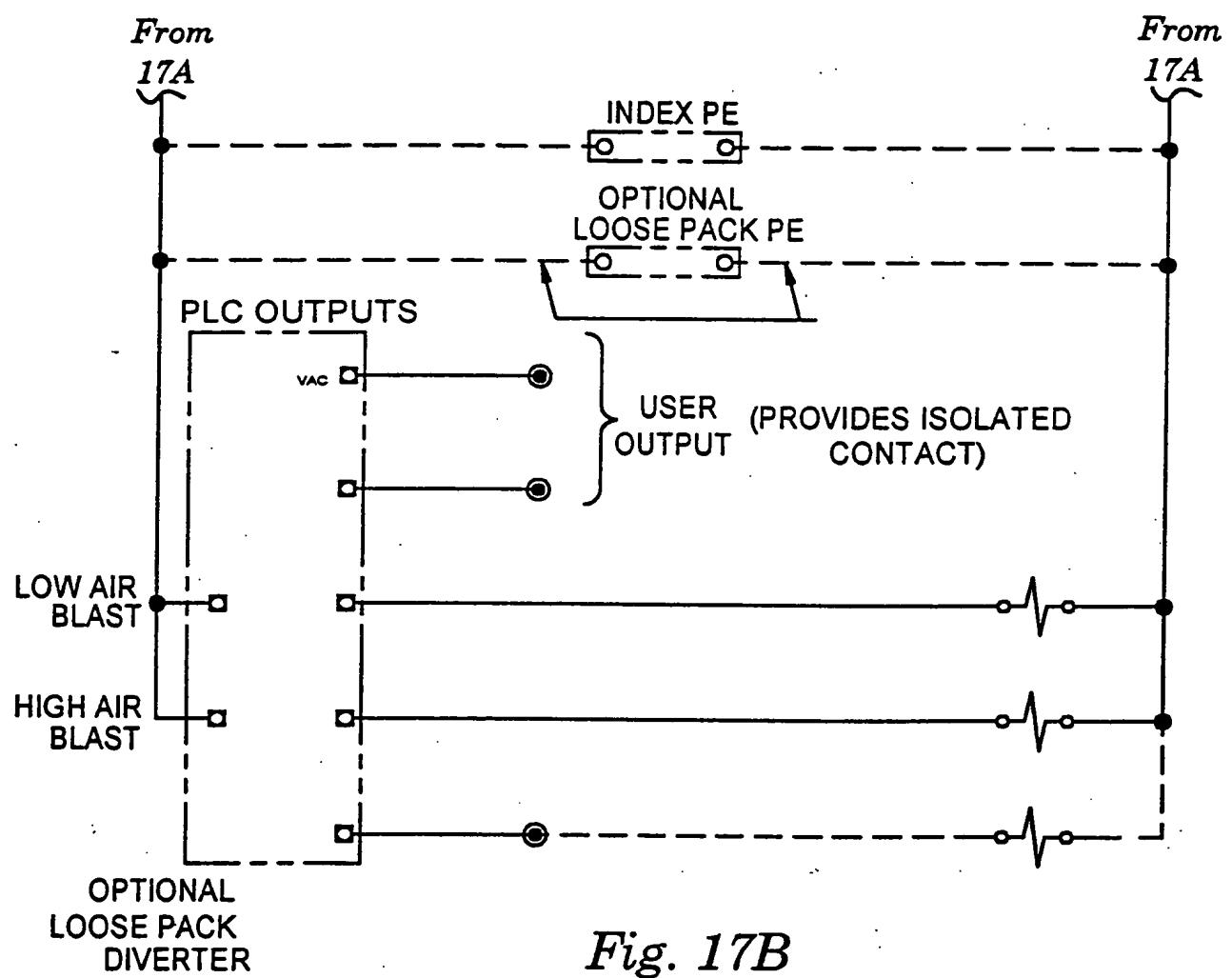
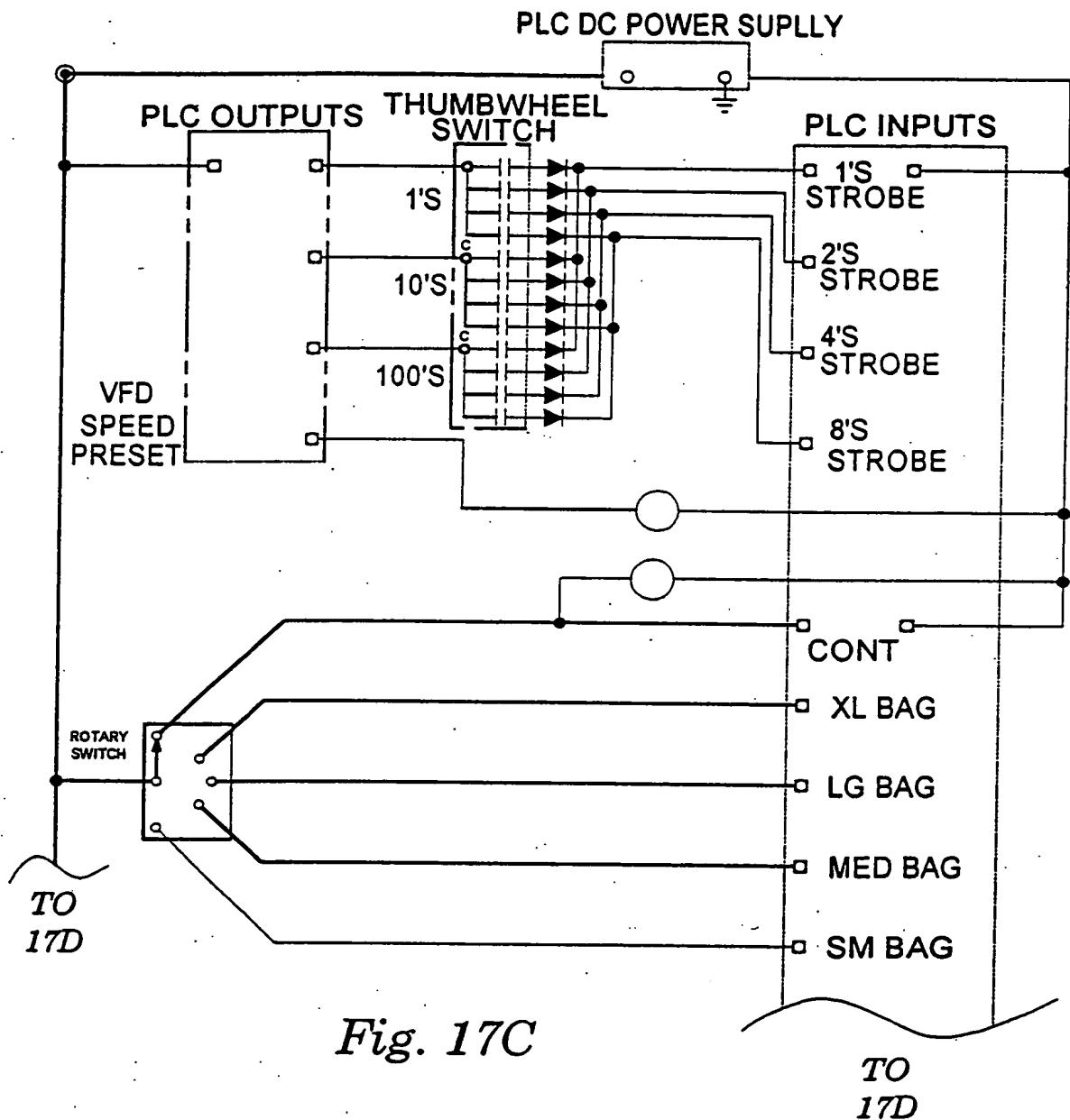
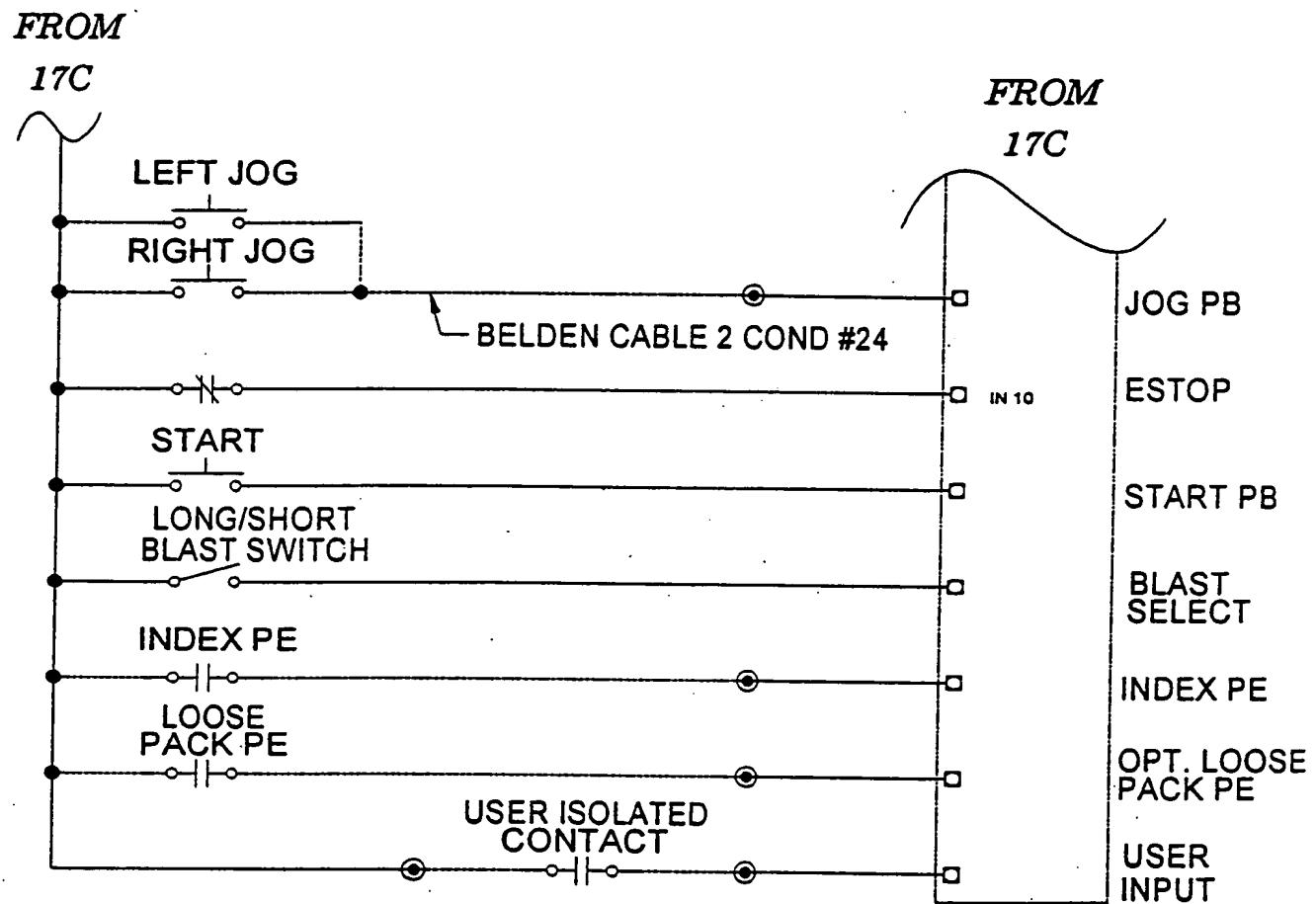


Fig. 17B





*Fig. 17D*

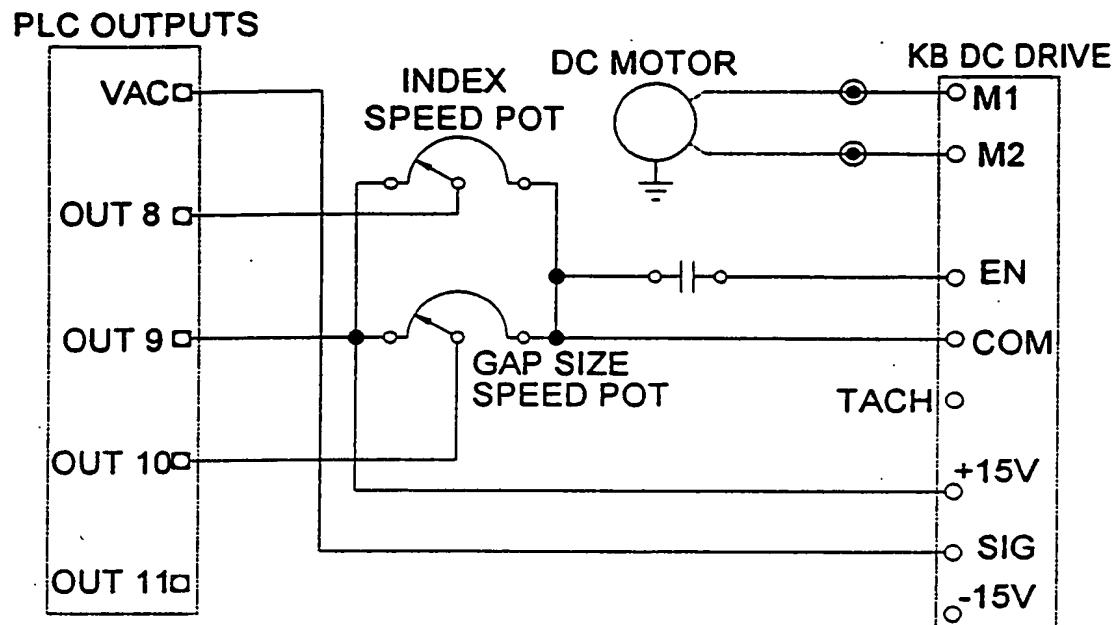


Fig. 17E

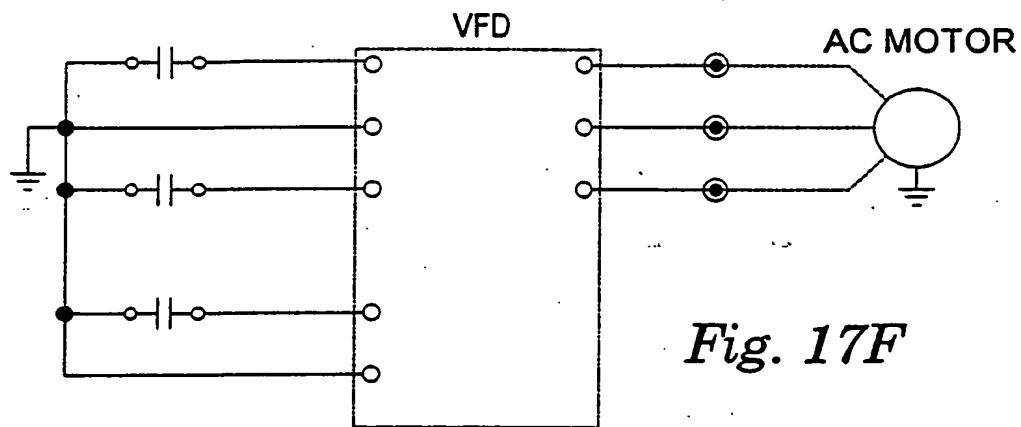


Fig. 17F

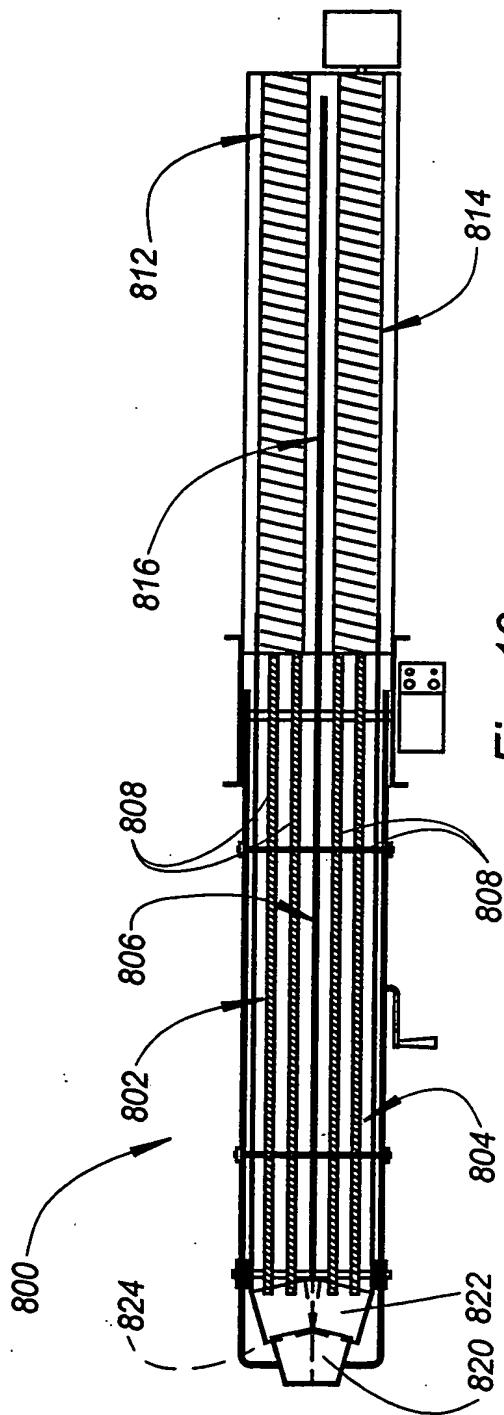


Fig. 19

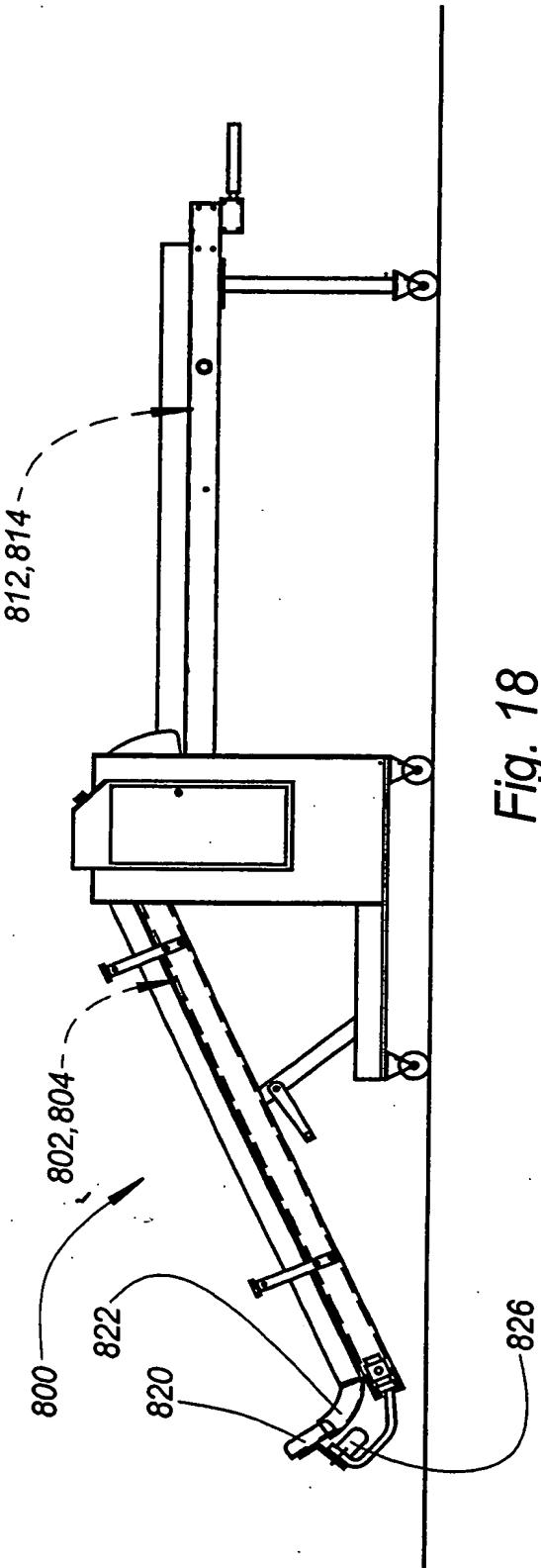
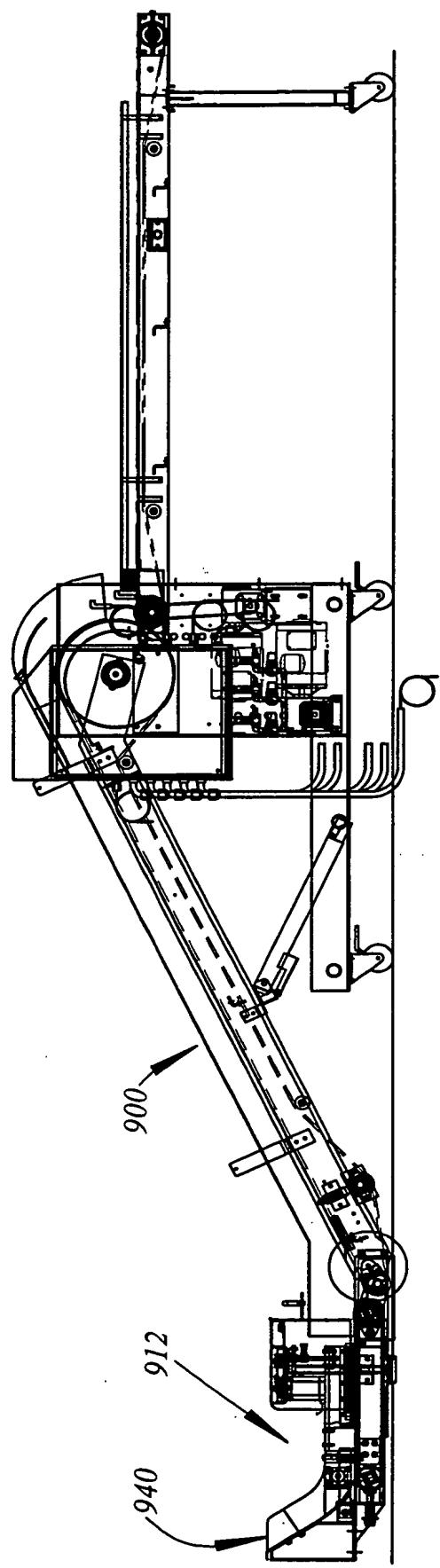
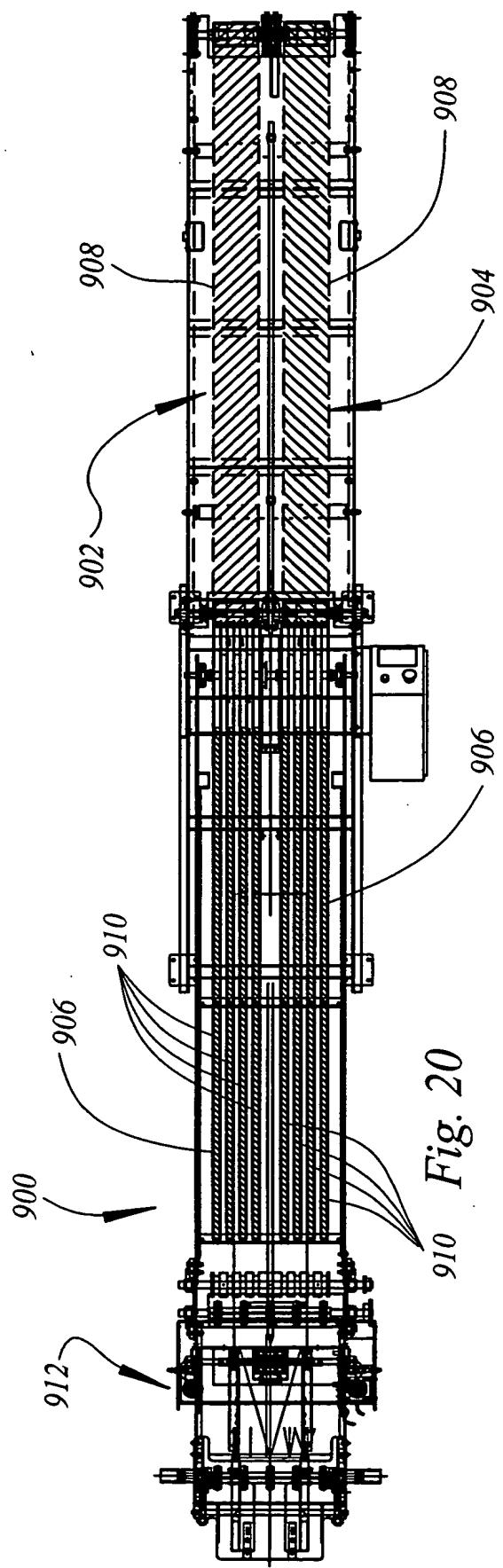


Fig. 18



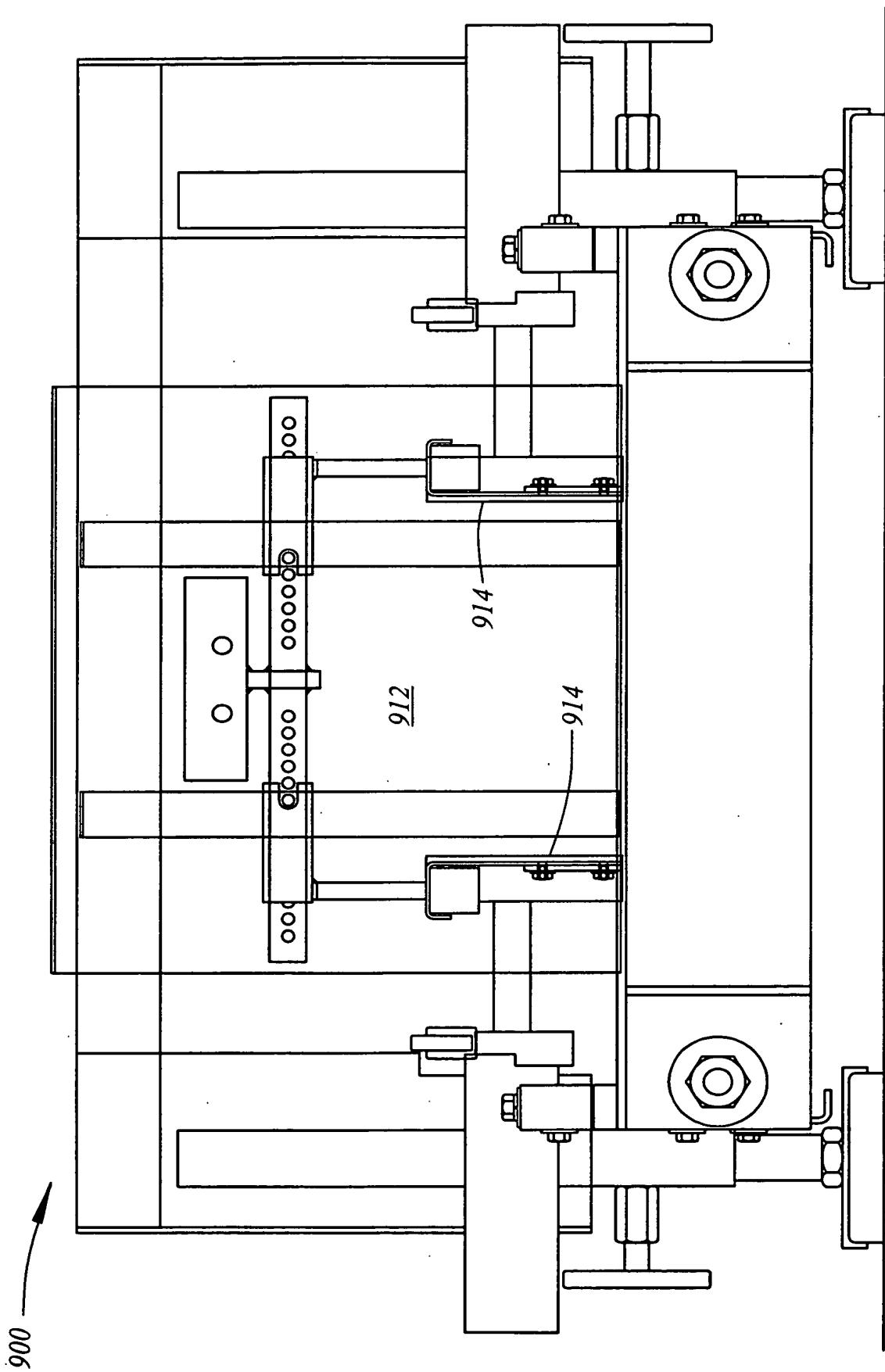
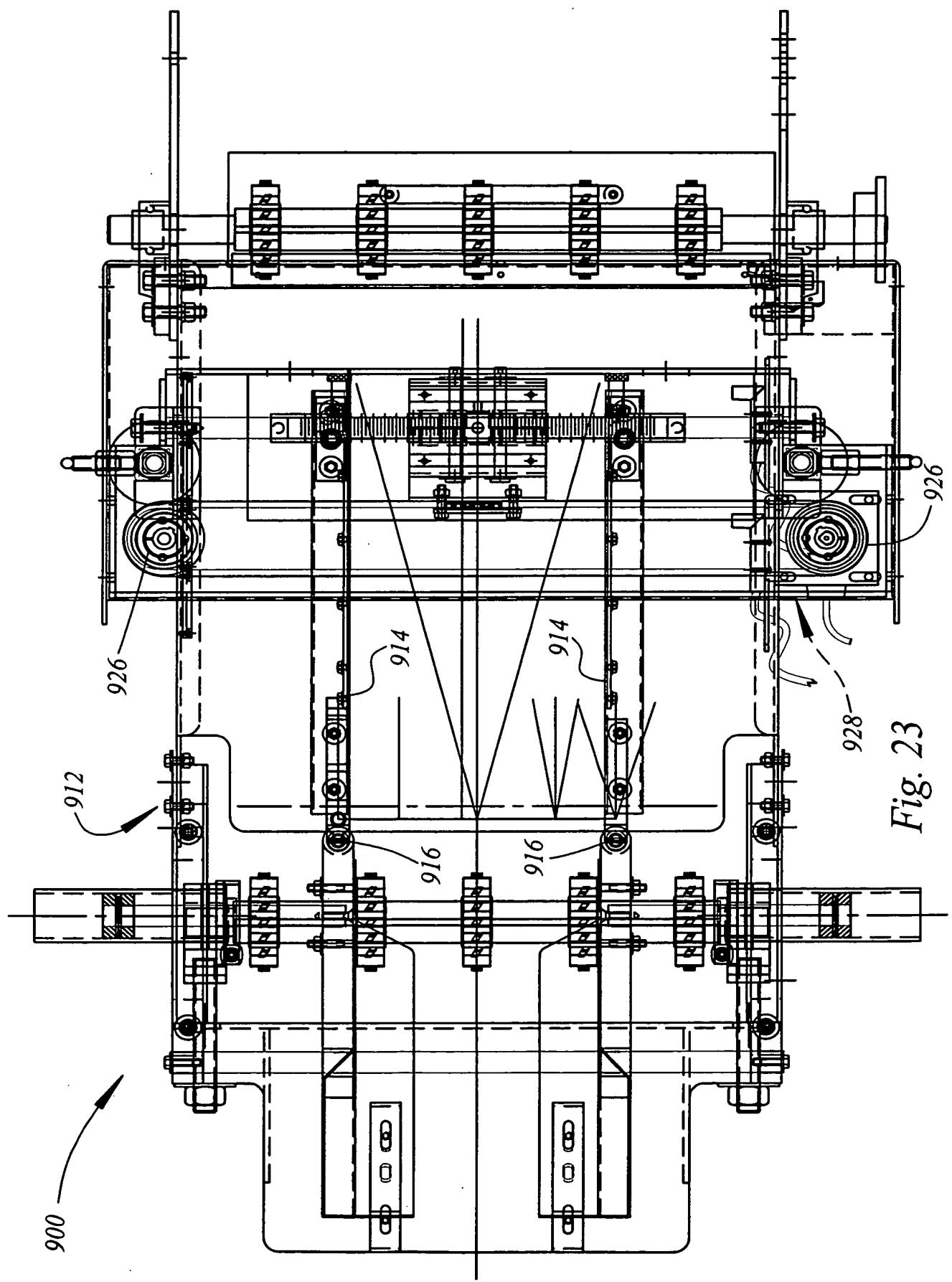
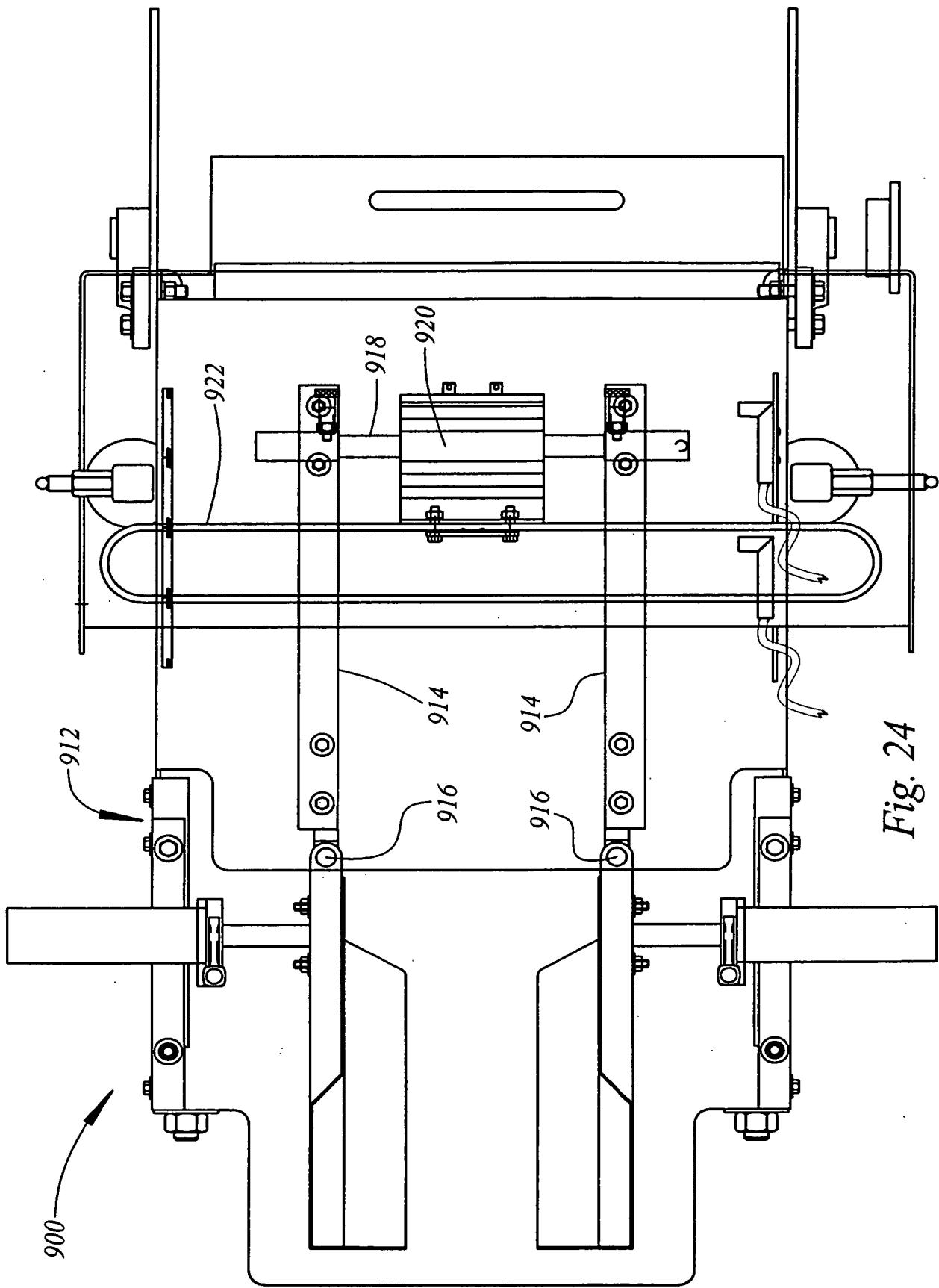
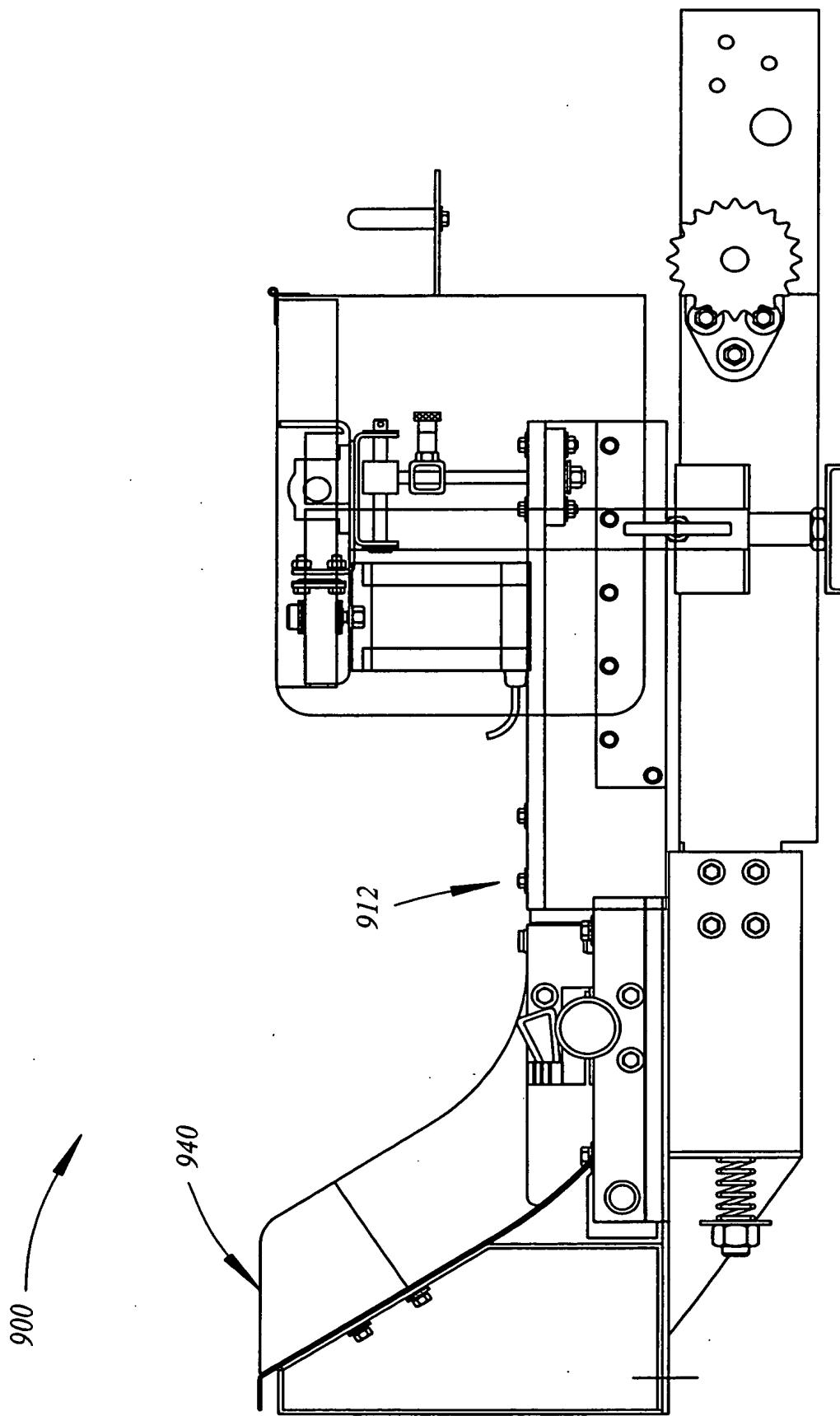


Fig. 22







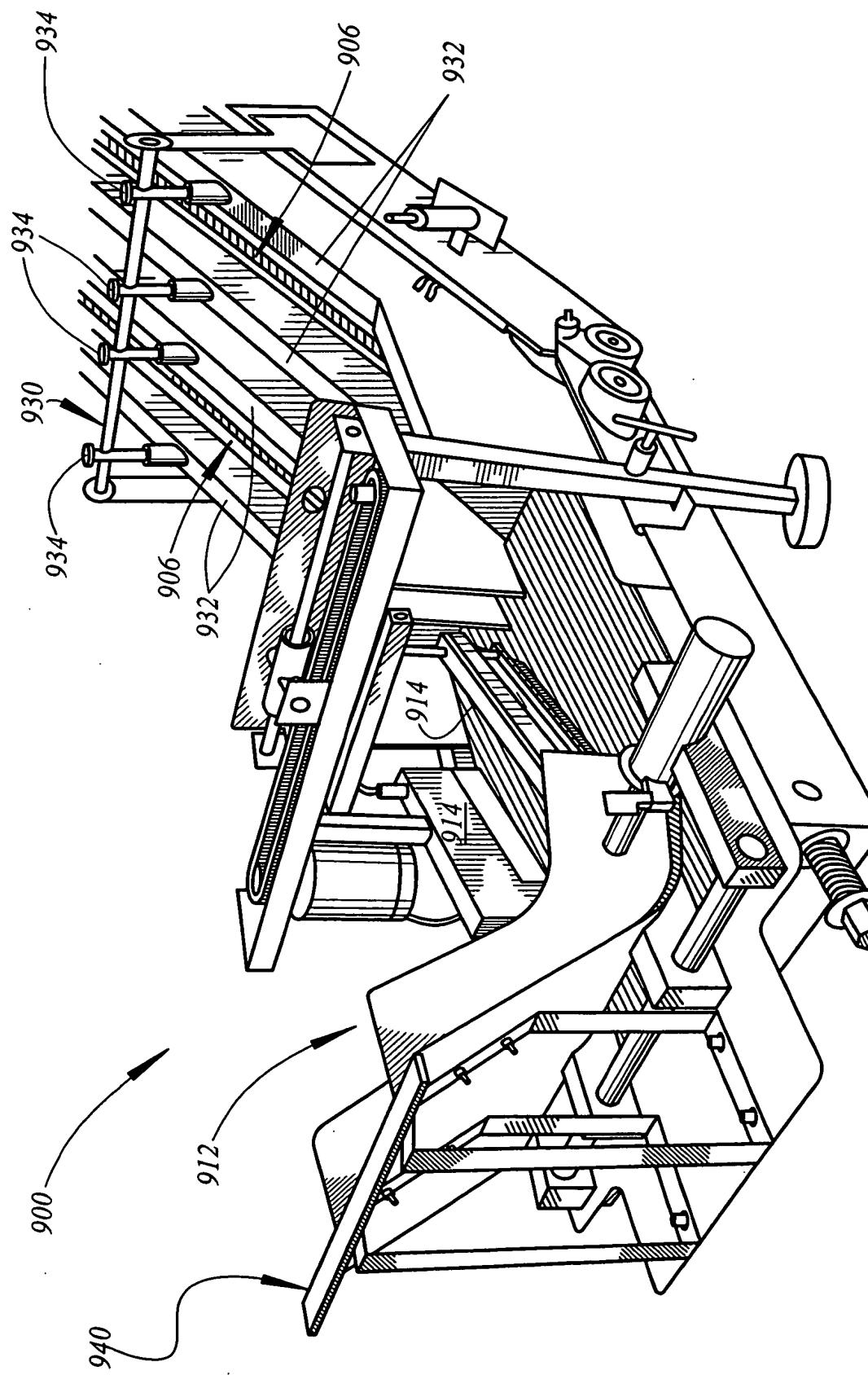


Fig. 26

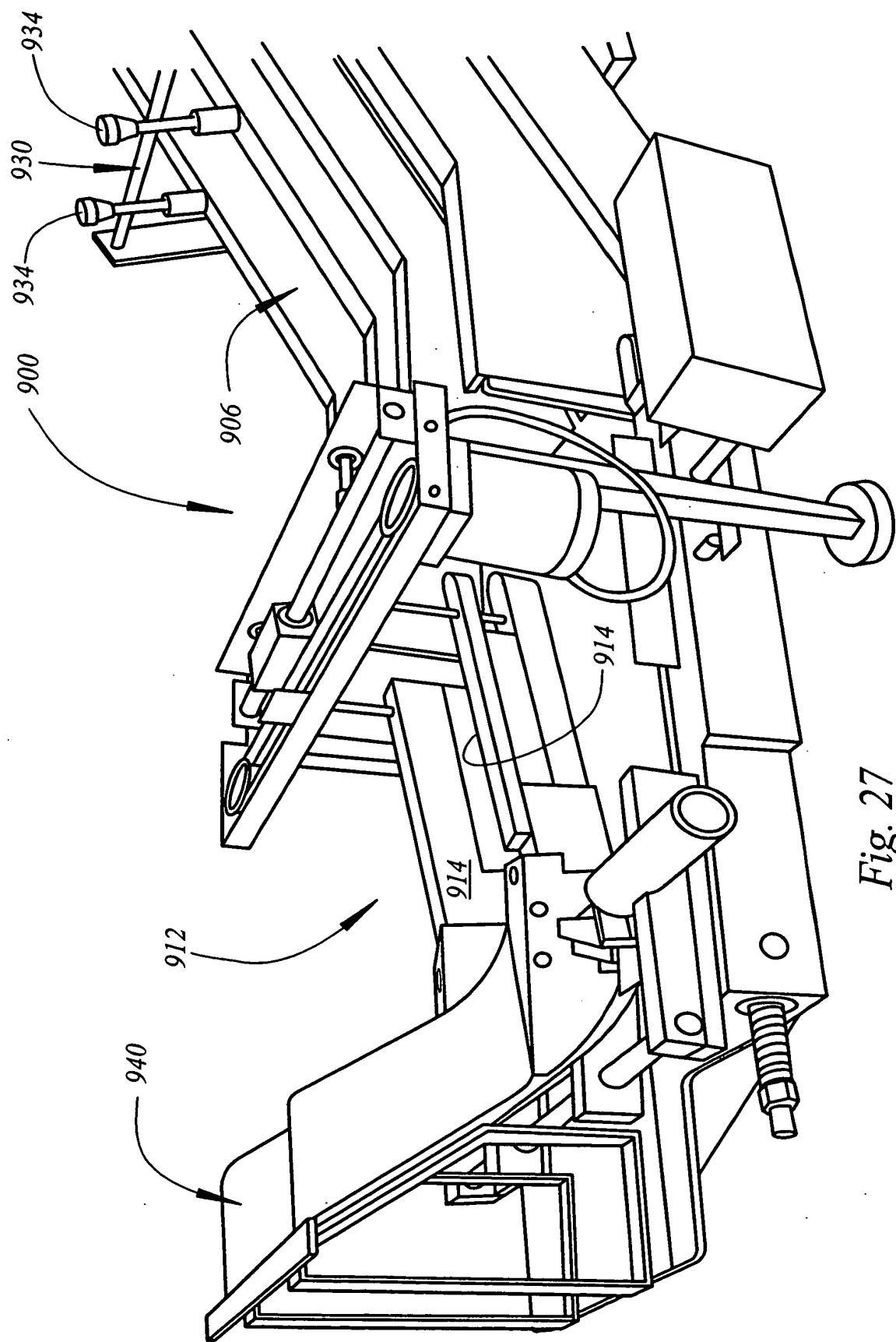


Fig. 27

900

*Fig. 28*

